988

United States
Department of
Agriculture

Food Safety
and Inspection
Service

Combined Compilation of Meat and Poultry Inspection Issuances For 1988

A 110.9/2:

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Part 8.55(e)	**Cooling provisions (last four sentences)**

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 1-88 | 1-12-88

CHANGE IN COMPLETING OFFICIAL SAMPLE FORMS FOR DOMESTIC SAMPLES ANALYZED BY FSIS LABORATORIES

This notice is to inform FSIS domestic inspection personnel that the Field Service Laboratories (FSL) and Field Service Contract Laboratories (FSCL) will no longer check off certain blocks on official forms accompanying domestic samples submitted for food and residue analyses. FSL and FSCL personnel are not familiar with the history or circumstances of samples and, therefore, cannot determine compliance or followup action. Accordingly, FSLs and FSCLs shall discontinue checking the "compliance" or "action by inspector" blocks for the following forms:

FSIS Form 6000-1, Block 20 (FSIS Form 6000-1 will be replaced by FSIS form 10,000-2 at the next printing)

FSIS Form 6200-1, Block 14

Numerical results and all other information reported will remain the same. The inspector in charge should evaluate the numerical results and/or other reported information and:

1. Take appropriate action when the results exceed published compliance standards.

2. Consult through supervisory channels when questions arise about standards or actions to be taken.

W. J. Hanna

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION:	NOTICE EXPIRES:	OPI:
All MPI offices T/A Inspectors, Plant Mgt., T/A Plant Mgt., SCI Offices, Compliance Offices, TRA, ABB, R&E, AID	January 12, 1989	SCI/FSLD

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS NOTICE | 2-88 | 3-22-88

AUTOMATIC POULTRY SLAUGHTER LINE EQUIPMENT; CONDITIONS OF USE

Section 381.53(a)(1) of the Federal poultry products inspection regulations requires that equipment used for preparing poultry and poultry parts in official establishments shall be constructed in such a way and of such material that will facilitate thorough cleaning and ensure cleanliness throughout preparation to avoid adulteration and misbranding of such products. For this purpose, FSIS approves the use of all equipment to be used in official establishments. Equipment found to be acceptable for their proposed uses are listed in MPI-2, Accepted Meat and Poultry Equipment, along with conditions of use for certain equipment, as provided for in section 381.53(a)(3) and (4) of the regulations.

The MPI-2 provides that the surfaces of automatic poultry slaughter line equipment contacting carcasses must be sanitized between each bird. Sanitization must be accomplished by flushing the contact surfaces with either 180°F water or with water containing 20 ppm residual chlorine at the point of use. On January 11, 1979, in a memorandum from Dr. R. J. Prucha, then Acting Assistant Deputy Administrator, MPIO, FSIS temporarily suspended enforcement by inspectors of this condition of use for such equipment located between the point of carcass transfer and completion of inspection, except for mechanical carcass eviscerators. This action was taken after disputes arose concerning the efficacy of such a practice.

Since then, the Agricultural Research Service (ARS) has conducted studies on the use of chlorine and has found that sanitizing equipment with chlorine at 20 ppm drastically reduces bacteria, such as Salmonella. Due to the results of the ARS studies, FSIS is reinstituting its policy that product-contact surfaces of all automatic poultry slaughter line equipment located between the point of carcass transfer and completion of

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inspection should be sanitized between each bird with water containing at least 20 ppm residual chlorine. Alternatively, establishment owners or operators may use 180°F water since water at this temperature is recognized for its sanitizing effect. Other alternative sanitization methods may be submitted for approval to the Sanitation Branch, Facilities, Equipment, and Sanitation Division, Technical Services, Food Safety and Inspection Service, U.S. Department of Agriculture, Washington, DC 20250.

Chlorination devices or approved alternatives must be in place and effectively operating no later than 90 days from the date of this notice to ensure continued compliance with section 381.53(a)(1) of the regulations.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 7-88 | 2-19-88

REPORT OF ANIMAL OR LOTS DIAGNOSED AS CYSTICERCOSIS

The purpose of this notice is twofold as follows:

1. To alert inspectors of the change in submission of cysticercosis samples from cattle carcasses, and

2. To inform inspectors of the changes in the reporting and distributing of the VS Form 2-11, Report of Diseased Animals Found at Slaughter Establishments, for carcasses or lots of cattle and swine diagnosed as having lesions of cysticercosis.

SUBMISSION OF SPECIMEN

1. Cattle - It is no longer necessary to submit samples with live cysts from cattle carcasses to the Veterinary Services Laboratory in Ames, Iowa. An option exists whereby if an inspector in charge wishes to confirm a diagnosis of cysticercosis, the specimen may be submitted to the FSIS Pathology Group, Regional Multidisciplinary Laboratory (RML), in your region. The sample must be accompanied by an FSIS Form 10,000-2, Laboratory Report.

2. Swine - Lesions diagnosed with Cysticercus cellulosae must be submitted to the FSIS Pathology Group, RML, in your region to confirm the diagnosis. The swine samples must also be accompanied by FSIS Form 10,000-2, Laboratory Report.

REPORTING AND DISTRIBUTING

1. Cattle - When carcasses or lots of carcasses have been diagnosed as infected with cysticercosis, a VS Form 2-11 must be completed.

2. Swine - VS Form 2-11 must be completed when laboratory confirmation has been received verifying the cysticercosis diagnosis. In addition, if the animal's origin can be determined, local public health officials in the area should be notified.

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All information concerning identification and origin of the animal should be entered on VS Form 2-11 and copies are to be distributed as indicated on the form. Part 3 (yellow copy) of the form should be mailed directly to the Regional Staff Assistant for Livestock Slaughter for the region in which the establishment is located. Each week, the Regional Staff Assistant must collect and forward Part 3 of VS Form 2-11 to the following address:

U.S. Department of Agriculture
Food Safety and Inspection Service
Slaughter Inspection Standards and Procedures Division
Room 4444-South Building
Washington, DC 20250

If there are questions regarding these procedures, please call the Regional Staff Assistant for Livestock Slaughter in your region.

The information contained in this notice will be included in an FSIS Directive when Subpart 11-B of the MPI Manual is converted into the new issuance system.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 9-88 | 2-25-88

PHASING OUT THE MPI MANUAL

I. PURPOSE

The purpose of this notice is to:

1. Identify documents that supplement, update and replace the MPI Manual.

2. Update Agency personnel and users of the MPI Manual on the progress of the unified FSIS Issuance System.

II. INTRODUCTION

From the inception of the unified FSIS Issuance System in 1984, and before the process of converting material from the MPI Manual into directives could begin, months of preliminary work to identify material and to make assignments to Offices of Primary Interest had to be completed. By mid-1985, progress was underway with a noticeable increase in directives being issued.

One significant change was the distribution of materials to affected Agency personnel and to official establishments directly upon publication by headquarters. Several administrative and housekeeping adjustments have been made concerning (1) distribution of the issuances to Agency personnel, official establishments, Talmadge-Aiken inspectors and plants and to GPO subscribers, (2) removal of material from the manual that needed to be published as a regulation, and (3) distribution by the regions of combined compilations with the MPI Manual to new establishments and inspectors.

III. REFERENCE

FSIS Directive 2610.1, Rev. 3, dated 11/25/85.

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All MPI Offices, T/A Inspectors, Plant Mgt. T/A Plant Mgt., Science Offices, Compliance Offices, TRA, ABB, R&E, AID		PP/PO/RDU

IV. PUBLICATIONS THAT SUPPLEMENT AND UPDATE THE MPI MANUAL

The following resources are published periodically in order to permit all personnel to keep their reference materials current:

A. **Compilation of MPI Issuances.** The document, "Compilation of Meat and Poultry Inspection Issuances", is a compilation of MPI issuances printed and distributed periodically by GPO to interested persons and firms not receiving these materials directly from the Agency. At the end of each year, a combined compilation is prepared for distribution by GPO and regions so that new subscribers and new establishments will have available all updates to the MPI Manual.

B. **Index.** A numeric and subject-matter index of all (administrative and program issuances) FSIS Directives in effect. Issued annually.

C. **Checklist.** A listing of all (administrative and program) FSIS Directives and FSIS Notices published or discontinued during the specified period of time. MPI Manual and MPI Bulletins deletions are also contained in the checklist. Issued quarterly.

D. **Inventory.** A listing of current program-related FSIS Directives and FSIS Notices and the still-effective MPI Directives and MPI Bulletins. Also included are a list of all the forms that have been converted to the new numbering system, and a list of the cancelled manual parts. Issued semi-annually.

V. DISTRIBUTION AND REPRINT OF THE MPI MANUAL

A. **Current Users of MPI Manual.** As program-related FSIS Directives and FSIS Notices are published, Agency personnel and plant management will receive those issuances through normal distribution and mail channels. As those issuances are received, particularly the FSIS Directives, users should check to see if that issuance cancels a part of the manual, and if so cross out that part in the manual and note therein where the current instruction is located.

B. **Future Users of the MPI Manual.** Whenever there is a request or a need to distribute a complete MPI Manual, it is essential that all Combined Compilations to date accompany it to permit all required deletions and cross references to be made. The Regional Office will be furnished with a sufficient number of copies to accommodate these needs (just as is now being done with the combined regulation changes and, in the past, the combined manual changes).

C. Reprint of MPI Manual. During the planning stages of the new issuance system, it was expected that the manual would be phased out in a 3-5 year timeframe; therefore, the intent was not to republish the MPI Manual. However, due to the fact much of it is still operative, and numbers of copies are still being requested and distributed, and due to the large number of changes and deletions that have been made since its last complete revision, it has become necessary to reprint the manual. This publication will be sent to all Regional Offices to be distributed to new users only and still must be accompanied by subsequently published Combined Compilations to assure it is up-to-date.

VI. PROGRESS REPORT OF ISSUANCE SYSTEM

A. The goal of the unified Agency-wide Issuance System is to consolidate all material implementing Agency policies or procedures into one easily maintained and accessible system. The following progress has been achieved:

1. More than 80 parts of the MPI Manual have been deleted.

2. Approximately 90 FSIS Directives have been published with 50 directives consisting of material previously contained in various types of issuance under the old system.

3. Over 260 MPI Bulletins have been incorporated into FSIS Directives or cancelled.

B. Until the transition is complete, we will continue to have some portion of the MPI Manual or other pre-1984 issuances in effect. The need to maintain all materials carefully, filing and notating as directed, will continue to exist for the near future.

C. If there are any questions regarding information contained in this notice, please direct them to the Regulations Development Unit, Policy Office, Program and Planning Staff, 14th & Independence Ave. S.W., Room 3807-S, Washington, D.C. 20250. The phone number is 447-7163.

Administrator

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 11-88 | 3-7-88

CANNING REGULATIONS
QUESTION AND ANSWER GUIDE #2

The revised regulations covering the packing of heat processed, shelf-stable, canned meat and poultry products in hermetically sealed containers became effective on June 19, 1987. (See Sections 318.300-311 and 381.300-311 of the meat and poultry products inspection regulations. Please note that sections 318.310 and 381.310 concerning the training of supervisors are effective December 19, 1988.) Subsequent to publication of the revised regulations, but prior to their effective date, FSIS issued Notice 32-87, "Question and Answer Guide #1", on April 29, 1987, to promote uniform interpretation and application of the regulations. This notice, "Question and Answer Guide #2", has been prepared to provide answers to additional questions raised by FSIS personnel, processors, and trade associations.

Additional questions on the canning regulations should be directed, through appropriate channels, to:

USDA, FSIS, TS
Processed Products Inspection Division
Room 2159, South Building
14th & Independence Avenue, SW
Washington, DC 20250

Industry members should submit questions directly to the above address.

M. J. Horne

Deputy Administrator
Meat and Poultry Inspection Operations

Attachment

DISTRIBUTION:	NOTICE EXPIRES:	OPI:
All MPI Offices T/A Inspectors, Plant Mgt. T/A Plant Mgt., Science Offices, Compliance Offices, TRA, ABB, R&E, AID		TS/PPID

FSIS NOTICE 11-88
ATTACHMENT

CANNING REGULATIONS

QUESTION AND ANSWER GUIDE #2

CANNING REGULATIONS

QUESTION AND ANSWER GUIDE #2

1. QUESTION: Are products that rely on reduced water activity levels covered by the revised canning regulations?

ANSWER: Yes and no. Sections 318.300(d) and 381.300(d) define a "canned product" as a "meat [poultry] food product with a water activity above 0.85 which receives a thermal process either before or after being packed in a hermetically sealed container." Therefore, products that are intended to have a water activity of 0.85 or lower are not covered by these regulations. Some processors will partially dry a product to reduce its water activity level from, for example, 0.98 to about 0.89 to 0.93, and then subject it to a mild heat treatment (e.g., pasteurization) to obtain a safe and stable canned product. Such products are covered by the regulations and the recommended process schedules must list a maximum water activity level as a critical factor. Moreover, sections 318.303(a)(10) and 381.303(a)(10) of the regulations specify that product water activity levels are often critical to process schedule adequacy and should be measured, controlled, and recorded accordingly.

2. QUESTION: Are heat distribution data or other documentation always required to verify adequate temperature distribution within a retort or other thermal processing system?

ANSWER: Yes, except when "Batch, Still, Steam Retorts" (vertical or horizontal) are installed, equipped, piped, operated and vented exactly as described in sections 318.305(b)(1) and 381.305(b)(1) of the regulations. In that case, the establishment is not required to have any documentation attesting to the adequacy of air removal and temperature distribution within the retort(s).

3. QUESTION: When an establishment is operating more than one retort and heat distribution data or other documentation is required under sections 318.305(b) or 381.305(b) of the regulations, is separate documentation required for each individual retort?

ANSWER: Not necessarily. When two or more retorts are identical (e.g., size, dimensions, auxiliary equipment, operating procedures), there is no need to have documentation on file at the establishment demonstrating that each retort has been individually tested. However, the documentation required under sections 318.305(b) and 381.305(b) that is maintained on file must clearly identify the acceptable (or limiting) retort operating conditions. For example, the information should

address the range of container sizes; the use of retort crate divider plates (if applicable); and the number of retorts that could be simultaneously vented.

4. QUESTION: Are processors required to keep actual ("raw") data and test results from retort heat distribution studies on file at the establishment?

ANSWER: No. Sections 318.305 and 381.305, which require that such records be maintained, qualify the requirement with "or other documentation from the equipment manufacturer or processing authority...." Therefore, the documentation requirement may be met by other documentation (e.g. letter or report) which recommends venting procedures or documents the uniformity of temperatures in the processing system as long as this documentation contains sufficient information on the retort system to accurately describe the units tested and limiting conditions under which they can be operated.

5. QUESTION: Is a bleeder required for a temperature/time recorder probe on a "Hydrostatic Retort" when the probe is installed directly through the steam dome without the use of an external well?

ANSWER: No. During the preparation of the final rule, the word "well" was mistakenly deleted from the 5th sentences of sections 318.305(b)(4)(i) and 381.305(b)(4)(i). The sentences should

read, "Each probe well shall have a ... bleeder opening ...." Thus, a bleeder is required only when the temperature/time recorder probe is installed in an external well attached to the retort. A notice will be published in the Federal Register correcting the regulations.

6. QUESTION: Sections 318.305(c)(1)(i) and 381.305(c)(1)(i) state that the bulb (or probe) of the indicating temperature device on "Batch, Still, Water Retorts" must extend a minimum of 2 inches into the water. Are there any exceptions to this requirement?

ANSWER: No. However, many establishments have "Batch, Agitating, Water Retorts" that are used in the still mode (no agitation). Even when operated in the still mode, these retorts are still agitating retorts which are covered by sections 318.305(c)(2) and 381.305(c)(2) of the regulations. These sections have no requirement regarding the distance a bulb (or probe) must extend into the water.

7. QUESTION: When a continuous rotary retort stoppage is of a short duration and there is assurance that the temperature in the "cooker" shell(s) has not dropped, may operation of the retort resume without any other action being initiated?

ANSWER: Yes, provided the establishment maintains documentation on file demonstrating that stoppages of short duration do not affect the adequacy of the thermal process. Thermal

processing records, however, must provide assurance that the temperature in the "cooker" shell(s) has not dropped and entries must be made on the processing records regarding the handling of each stoppage. If the duration of the stoppage exceeds the time for which there is supporting documentation, product involved must be handled in accordance with sections 318.308(d)(1)(vi) and 381.308(d)(1)(vi).

8. QUESTION: What requirements apply to the water used in "Hydrostatic Retorts"?

ANSWER: Because the water in a "Hydrostatic Retort" is being "reused" to thermally process canned product, sections 308.3(d)(2) or 381.50(f) of the regulations apply. This means that reuse must be for the original purpose and that all equipment used to handle reused water must be constructed and installed so that it may be cleaned and drained, and is kept clean. If any portion of the retort's water that is considered "cooling water" is pumped from the retort (for example, from the outlet cooling leg to a cooling tower and back to the cooling leg), it is considered "recycled container cooling water" and is subject to the requirements of sections 318.305(h)(3) or 381.305(h)(3) of the regulations.

9. QUESTION: How often must an establishment conduct finished product examinations to comply with sections 318.309(d)(2)(i) or 381.309(d)(2)(i)?

ANSWER: While sections 318.309(d)(2) and 381.309(d)(2) state that only containers that appear normal shall be shipped, this requirement does not necessarily mean that each and every lot must be examined prior to shipment. An establishment is expected to implement "an appropriate sampling plan" or use "other means acceptable to Program employees." The frequency of container examinations may be based on several factors, such as the establishment's history of problems, the results of incubation testing, and questionable container integrity test results. (Note, however, that the FSIS employee will be expected to occasionally conduct an FSIS-developed condition-of-container examination to verify the establishment's compliance with this section. An FSIS directive on this subject is under development.)

10. QUESTION: Do the regulations require that container closure technicians and operators of retorts and other thermal processing systems have a trained supervisor present at the establishment at all times?

ANSWER: Yes. However, the word "direct" as used in sections 318.310 and 381.310 does not necessarily mean the immediate supervisor. Accordingly, if a trained supervisor's or manager's scope of authority extends to the thermal processing system operator(s) or container closure technician(s), even if one or more levels of supervision exists between the trained supervisor and the operator/technician, the establishment would be considered to be in compliance with this requirement. However, this supervisor must have successfully completed each area of instruction for which he/she is responsible as a supervisor and must physically be at the establishment during the supervisory period.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 24-88 | 5-25-88

GUIDELINES ON USE OF BAND-TYPE CARCASS SPLITTING SAWS

This notice is to advise FSIS personnel on the sanitary use of band-type carcass splitting saws in official establishments.

FSIS has approved the use of several makes of carcass splitting saws which have continuous, band-type blades that travel between a rear drive wheel or pulley and a front idle wheel. The wheels are enclosed in cabinets which have hinged, access doors. This equipment was accepted with the provision that such saws include an anti-drip device for the water flush system. The water flush is a trigger-activated system that washes bone dust and other debris from the blade. If the blade was not cleaned in this manner, the saw would not operate as effectively. However, this water flush is not an acceptable means of washing the interior cabinets, and further, it cannot be considered an acceptable sanitization method.

Wasted flush water must not be allowed to contact carcasses, operators, or surrounding equipment. Accepted band-type saws include drain hoses designed to contain and divert wasted flush water to a convenient drain without having the water flow across the floor. The following guidance is provided on the basic conditions which normally must be met to assure sanitary use of band-type splitting saws:

1. As currently designed and constructed, band-type saws are not acceptable for use prior to viscera inspection. Until a determination based on the viscera inspection can be made and

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the affected carcass is suitably identified, each carcass is presumed to be potentially suspect. Consequently, splitting saws would require sanitization between each carcass. This is an unrealistic condition of use given the current design.

2. If used following viscera inspection, band-type saws need only be sanitized after splitting carcasses which have been marked or tagged for further inspection or when abscesses or other hidden disease conditions or contamination are cut into during splitting.

3. A suitable area and accessory equipment (such as sterilizing tanks, racks, etc.) must be available for sanitizing the band-type splitting saws. A sanitization method is not acceptable unless all bone dust and other debris is removed from the housing PRIOR to the exposure of the saw blade to 180° F. water. In addition, the blade must be exposed to the 180° F. water for a minimum of eight seconds.

The following are methods in which sanitization can be accomplished most effectively:

a. The operator opens the front and rear cabinets of the saw, rinses the interior surfaces with water from a drop hose and closes the doors. The saw, with the blade running, is then submerged into a sterilizing tank for the eight second minimum. Alternatively, the establishment may be able to demonstrate that the front housing need not be opened since this area may be cleaned as well as sanitized by the submersion into the tank.

b. The operator opens the front and rear cabinets of the saw, rinses and sanitizes the surfaces with 180° F. water from a drop hose. In this event, the sanitizing area must be completely shielded so that the 180° F. water cannot splash into other areas thus becoming a safety hazard. Racks and other accessory equipment may also be necessary to prevent splashing of the water.

c. Devices may be installed or modified on the equipment in such a manner that the housing(s) can be completely flushed of bone dust and other debris. Following this "flushing", the saw could be submerged into the sterilizing tank or otherwise exposed to the 180° F. water in some alternative fashion. When a sterilizing tank is used, the front housing may not require this device if the establishment can demonstrate that the front housing is cleaned as well as being sanitized by the submersion into the tank.

Alternative methods may be submitted to the Sanitation Branch, FESD, in Washington, D.C., for approval. Inspectors in charge will monitor the establishment's activities regarding the sterilization of band-type saws, and, if sterilization activities are not followed, the inspector in charge will discontinue the use of this equipment.

The information contained in this notice will be included in the next publication of the MPI-2, "Accepted Meat and Poultry Equipment Book".

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C

FSIS NOTICE | 31-88 | 7-8-88

SUBMITTAL OF LABELING MATERIAL

The purpose of this notice is to inform establishments and plants submitting labeling to the Standards and Labeling Division that, in some instances, each transmittal form must be accompanied by two copies of the labeling. This is needed only in those situations where information is offered on both the front and back of single sheet type labeling.

The common practice is to attach single sheet type labeling to the transmittal with one side visible. In those instances where labeling information is on the back, the information is easily overlooked upon review and is not documented for future reference. Firms with such labeling are asked to affix two copies on the transmittal form, one displaying the front of the labeling, the other displaying the back, to clearly show all the information. This practice is to be followed for both sketch and final approval.

W. J. Horne

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Offices, /A Inspectors, Plant Mgt., /A Plant Mgt., SCI Offices, omp. Offices, TRA, ABB, R&E, ID	NOTICE EXPIRES:	OPI: TS/SLD

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 40-88 | 8-26-88

CHANGES TO THE AUTOMATED IMPORT INFORMATION SYSTEM (AIIS)

This notice announces the modification of the AIIS to accommodate the amended standard of identity for frankfurters and similar cooked sausages with regard to the new percentage fat/added water limitations. The modification is effective September 15, 1988.

Effective April 14, 1988, FSIS amended the standard of identity in the MPI Regulations for frankfurters and similar cooked sausages (9 CFR 319.180) and cheesefurters and similar products (9 CFR 319.181) to contain no more than 40 percent of a combination of fat and added water, with a maximum fat content of 30 percent. Previously these products had a limit of 10 percent added water and 30 percent fat. Refer to Attachment 1 for a list of applicable imported products with their corresponding product codes.

The AIIS was designed to address fat and water separately, each having its own Type of Inspection (TOI). The TOI of 62 for fat will remain unchanged. The TOI of 55 for water has been eliminated from the applicable product codes. A new TOI of 176 for the revised percentage fat/added water limitations has been added. The zone concept makes allowances for reasonable variations attributable to normal sampling variability and analytical error and is still in effect. New zones, however, have been established and are provided in Attachment 2.

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AID, IFO, All MPI Offices, SCI Offices, Comp. Offices, TRA, ABB, R&E, IPM		IP/PDD

For further information or inquiries, please contact the Chief, Inspection Assignment Branch, Program Development Division, International Programs, through normal channels.

Patricia Stolfa

Deputy Administrator
International Programs

Attachments
1-Frankfurters and Similar Cooked Sausage Product Codes
2-Sample Limits Table for Cooked Sausage Products

Attachment 1

FRANKFURTERS AND SIMILAR COOKED SAUSAGE PRODUCT CODES

Product Code	Product Name
AGBCC3	Cocktail Franks
AEGCC3	Sausage Cured Cook Smoke
AEGCC4	Sausage Cured Cook Smoke w/extenders
BEGCC3	Sausage Cured Cook Smoke
BEGCC4	Sausage Cured Cook Smoke w/extenders
PBGCC3	Sausage Cured Cook Smoke
PBGCC4	Sausage Cured Cook Smoke w/extenders
PEGCC3	Sausage Cured Cook Smoke
PEGCC4	Sausage Cured Cook Smoke w/extenders

SAMPLE LIMITS TABLE FOR COOKED SAUSAGE PRODUCTS
(Normal and Tightened Criteria)

ZONED LAB SUB TYPE OF INSPECTION	END VALUE	ZONE A	ZONE B	ZONE C	ZONE D	ZONE E	END VALUE	ZONE Q
	<	<	<	<	<	>	>	<
ADDED WATER	-5.0	10.0	11.1	12.1	13.1	13.1	15.0	10.0
FAT	15.0	30.0	30.7	31.2	31.7	31.7	35.0	30.0
FAT & WATER COMBINATION	20.0	40.0	41.2	42.3	43.4	43.5	45.0	40.0

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 51-88 | 10-20-88

PREVENTION OF RECONTAMINATION

This notice is being issued as a reminder that special care must be taken to avoid recontamination of ready-to-eat products that may be eaten without further heating. Each meat and poultry establishment should examine its processing procedures, i.e., traffic flow, product handling, packaging, to assure that ready-to-eat products do not come in contact with raw products that may be contaminated.

In addition, since fully cooked or ready-to-eat products must be free of Salmonella, the process of applying raw leaf (abdominal) fat to such products to diminish the effects of drying or any other reason is prohibited due to the possibility of Salmonella contamination.

W. J. Hanne

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Mgt., T/A Plant Mgt., Sci. Offices, Comp. Offices, TRA ABB, R&E, AID	NOTICE EXPIRES:	OPI: TS/FESD

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

5400.1	9/21/88

INSPECTION SYSTEM GUIDE (ISG)

I. PURPOSE

This directive transmits the FSIS Inspection System Guide to be used with the Performance Based Inspection System (PBIS).

II. [RESERVED]

III. [RESERVED]

IV. REFERENCES

Federal Meat Inspection Act;
21 U.S.C. 601 et seq.;
Poultry Products Inspection Act;
21 U.S.C. 451 et seq.;
MPI Regulations, 9 CFR, Chapter 3;

V. ISSUANCE OF INSPECTION SYSTEM GUIDE

The ISG provides a uniform structure for all inspections and reviews of establishments. This guide summarizes requirements and compliance standards for critical control points, regulatory references within existing FSIS issuances, and inspection tasks to be applied to monitor or to review establishment compliance.

Changes in the FSIS inspection system will be reflected in periodic updates of the ISG.

Lester M Crawford
Administrator

Attachment

DISTRIBUTION: FSIS Inspectors and Plant Management

OPI: TS/PPID

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7110.2 Rev. 1	10/3/88

+[UPDATE OF]+ PROTEIN FAT FREE (PFF)* [INSTRUCTIONS]+**

I. PURPOSE

The purpose of this directive is follows:

1. To provide +[updated]+ information regarding the +[reporting of PFF Absolute Minimum Violations, and]+

2. To transmit an updated Questions and Answers Guide to the PFF Regulation, and

3. +[To transmit PFF Cured Pork Products Codes.]+

II. CANCELLATIONS

FSIS Directive 7110.2, dated 4/16/86
FSIS Directive 7110.2, Amend. 1, dated 6/26/86

III. REASONS FOR REISSUANCE

To abolish the PFF Toll Free Telephone Line, update the Questions and Answers Guide, and add an attachment which specifies product codes for PFF.

IV. REFERENCES

MPI Regulations, Sections 318.19, 319.104, and 319.105.

V. +[REPORTING PFF ABSOLUTE MINIMUM VIOLATIONS

The PFF Toll Free telephone line for reporting Absolute Minimum Violations (AMV) of official results from accredited laboratories is terminated as of this directive. All future AMV are to be reported to the Regional Office by the inspector in charge (IIC) to verify calculations and coordinate the action to be taken. Operational questions are to be directed to the processing staff officer in the Regional Office.]+

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Hq and Field Compliance Offices, TRA, ABB, R&E, AID, ICL

OPI: TS/PPID

Prior to +[calling the Regional Office to report PFF sample results]+, the IIC must have available the following information:

Establishment Number
Inspector Name
+[Group involved
Product codes (s) (See Attachment 3.)]+
Product Name on Label
Meat Protein Analysis from Submitted Sample
Fat Analysis from the Submitted Sample
Sample Request Form Number
+[Three-Digit Sample Number]+
PFF Value (Calculated by IIC)
Group from the Sample Request Form +[(and Product Code)]+
Sampling Phase (Periodic, Daily, Retention)

The data provided by the IIC will be entered into the computer for calculating the PFF Value, Group Value, Product Value or, in the case of retention, the average PFF sample value. +[These calculations on the PFF computer will take precedence over the IIC's calculations.]+ Instructions will be given +[to the IIC]+ on the action to be taken; e.g., retain product, release product, relabel product, change sampling phase, or identify products to be sampled.

VI. TRANSMISSION OF QUESTIONS AND ANSWERS GUIDE

Two video tapes are available from the Area Offices. The "Guide for PFF Analysis Sampling Program" dated July 1985 is available from the Regional Office and should be in all establishments producing cured pork products under PFF.

The attached question and answer guide was prepared in order to provide uniform interpretation and application of the regulations.

W. S. Horne

Deputy Administrator
Meat and Poultry Inspection Operations

ATTACHMENTS

1 Questions and Answers Guide - Cured Pork Products
+[2 Table to Determine X% on Retained Product Label When Fat and PFF are Known
3 Product Codes and Minimum PFF]+

CURED PORK PRODUCTS
QUESTIONS AND ANSWERS

TS, PPID
FSIS

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I. PRODUCTS COVERED

1. **Question:** Are "canned, deviled ham, or ham loaf, and ham sausage" covered by the PFF regulation?

Answer: No. The only comminuted products covered by the PFF regulation are those labeled as "ham patties", "chopped ham", "pressed ham", and "spiced ham".

2. **Question:** Are country hams, country style hams, dry cured hams, and country pork shoulders covered by the PFF regulation?

Answer: No. These products are covered under 319.106 of the regulations.

3. **Question:** Are bacon and miscellaneous cured pork products such as hocks, ears, snouts, feet, knuckles, tails, fat back and jowls covered by the PFF regulation?

Answer: No. +[However, "Canadian Bacon" which is essentially a cured pork loin must meet the PFF standard for loins (product code 04).]+

4. **Question:** If an inspected and passed product is only being resmoked or sliced, is it subject to PFF sampling?

Answer: No, provided that the resmoked or sliced product bears the same common and usual name and qualifying statement (if any) as the initial product.

5. **Question:** Does the name of the cured pork product affect whether the product is subject to the PFF regulations?

Answer: Yes. If a fanciful name such as Deli Roll is used in lieu of the common and usual name, the product is not subject to the PFF regulations and there is no restriction on the added substance. However, descriptive labeling and a demonstration that the product is not nutritionally inferior to the traditional product may be necessary for some products.

II. LABELING AND STANDARDS

6. **Question:** When are label applications stamped "Requires a QC Program?"

Answer: All labels for cured pork products labeled "(X)% of weight is added ingredients" will be stamped with the QC stamp. The +[only]+ exception to this is when the transmittal form has a statement on it such as "THIS LABEL IS TO BE USED FOR RELABELING RETAINED PRODUCT ONLY."

7. **Question:** Can labels for "ham and water product-X% of weight is added ingredients" be approved with a blank space where the percentage normally appears?

Answer: Yes, but only for relabeling purposes. The transmittal form must state that the label is only intended for use in relabeling and then only by the IIC who will determine the figure to be stamped in the space provided. The labels will not be stamped "Require a QC Program".

8. **Question:** When are qualifying statements required?

Answer: Qualifying statements are needed on all products requiring terms such as "with natural juices", "water added" and "(X)% of weight is added ingredients."

9. **Question:** What portion of the labeled product name is considered the qualifying statement for marking purposes?

Answer: That portion of the name which is in addition to the common and usual name.

Example:

Common or Usual Name	Qualifying Statement
Ham with Natural Juices	With Natural Juices
Ham Water Added	Water Added
Ham and Water Product 20% of Weight is Added Ingredients	20% of Weight is Added Ingredients

10. **Question:** Are plants able to "Label out of trouble"?

Answer: Yes, on a lot-by-lot basis during the retention phase, +[and by changing the label such as from "ham" to "ham with natural juices.]+

11. **Question:** Is it possible to relabel retained products rather than returning them to the official establishment?

Answer: Yes,+[under FSIS supervision.]+

Question: Is the relabeling of canned ham permitted?

Answer: Yes.

13. **Question:** How should canned, lithograph labeled product be relabeled?

Answer: The method of relabeling should be proposed by the processor for FSIS approval. For example, the product may be repackaged in consumer size containers and relabeled accurately. On consumer size cans FSIS permits pressure sensitive stickers, if the adhesive is a type that will not permit the sticker to be removed.

14. **Question:** Can retained product be down-labeled using pressure sensitive stickers?

Answer: Yes, provided the adhesive is a type which will not permit the sticker to be removed and provided the sticker meets the applicable size/color requirements.

15. **Question:** If a processor is manufacturing a water added product and the product fails to meet the standard for water added and can be relabeled as a _____ and water product-X% of weight is added ingredients, how can the X% to be shown on the label be determined?

Answer: There are several methods which can be used to determine the amount of added ingredients to be declared on the label of X% product and any of them which may be adequate. Two of these methods are: (1) yield determinations based on plant records such as comparisons between the green weight and the finished weight of the product; (2) use of the USDA chart +[(see Attachment 2)]+.

16. **Question:** Since the PFF regulation requires a quality control program for the production of an X% product, is a processor who gets into trouble with water added product (product which does not meet the water added standard) allowed to relabel the product as X% product without having a quality control program?

Answer: Yes. However, if such production becomes the rule rather than the exception, the processor will be prohibited from producing more X% product until a quality control program is approved for use.

17. **Question:** Can Ham and Water Product be 50% ham and 50% other ingredients?

Answer: No. A ham and water product must be more than 50% ham.

18. **Question:** Are the PFF values the same for all products?

Answer: All products which are labeled with the same common and usual name (including the qualifying statement) must comply with the same standard. For example, a canned ham--water added, and a smoked ham--water added, must comply with the same PFF standard.

19. **Question:** What is the meaning of the term "cooked" which is used in the regulations?

Answer: The term "cooked" is used in the PFF regulation to refer to all processes where heat is applied to the product. For example, products labeled smoked, cooked, or fully cooked will be in the cooked category.

20. **Question:** If a product is heat treated for the destruction of live trichinae, why is it considered cooked by this regulation?

Answer: When a product is heated, the heating process will have a concentrating effect on the protein. Therefore, products that are heat treated are considered cooked for the purpose of this regulation and must meet the appropriate PFF standards.

21. **Question:** Is there any allowance made for the differences in protein content of fresh and PSE pork or frozen pork?

Answer: No.

22. **Question;** What is the PFF value for "Cured Pork"?

Answer: "Cured Pork", uncooked or heat treated, made from any combination of hams, loins, shoulders, butts, or picnics, in whole or in part, which is labeled; e.g., as a part of the product name, in the ingredients statement, qualifying statement, starburst, etc., to indicate the presence of any of the above parts is subject to the PFF value for pork shoulder. These products may be sectioned, chunked, diced, or ground.

"Cured Pork" which is not labeled to indicate the presence of hams, loins, shoulders, butts, or picnics or "cured Pork" made from pork parts not covered by the PFF regulations; e.g., bellies, jowls, hocks, ears, fat-back, tails, etc., is not subject to the PFF regulations. If these products are subjected to heat treatment, the products must come back to the fresh uncured weight unless the product name specifically indicates the presence and percentage of the added substances above the fresh uncured weight. (See Policy Memo 084 issued by the Standards and Labeling Division.) If not subjected to heat

treatment, the product may contain up to 10 percent added substance without label declaration. If more than 10 percent added substance is added, the presence and amount of the added substance must be declared as a part of the product name. Examples of acceptable names are "Cured Pork and X% Water" and "Cured Pork and Water Product-X% of Weight is Added Ingredients". Whenever a percent is included in the product name, a partial quality control (PQC) program is required. The above applies to "dry salt cured" product also.

23. **Question:** What is the PFF value for raw "cured pork trimmings"?

Answer: The PFF concept is not applicable to trimmings. The product may contain up to 10 percent added substance without label declaration. If more than 10 percent added substance is present, the presence and amount of the added substance must be declared as a part of the product name. Examples of acceptable names are: "Cured Pork Trimmings and X% Water" and "Cured Pork Trimmings and Water Product-X% of the Weight is Added Ingredients". Whenever a percent is indicated in the product name, a PQC program is required.

24. **Question:** How should a mixture of trimmings from various uncooked cured pork products be labeled?

Answer: A processor wishing to combine the trimmings from uncooked cured pork product, such as hams which were injected with various levels of curing solutions, must label these trimmings indicating the highest level of substances added over 10 percent, e.g., "Uncooked Cured Ham Trimmings Injected With Up to 25 percent of a Solution of Water, etc." A PQC program is not required.

25. **Question:** Can +[more than one unit]+ of unlabeled or unmarked PFF controlled cured pork product be shipped in a fully labeled immediate container?

Answer: No. Each unit of PFF controlled cured pork product must at least bear the inspection legend, the curing statement, and the appropriate qualifying statment (if applicable).

26. **Question:** Since FSIS permits "down labeling" under PFF, can all products be down labeled to an X% product?

Answer: No. Only products produced to meet the water added requirement may be down labeled to an X % product. Products such as ham or ham with natural juices may not be down labeled to an X % product.

27. Question: Is labeling approved for less than 20 % added ingredients for an X % product?

Answer: No. However, labels submitted with less than 20% added ingredients are evaluated on a case-by-case basis.

28. Question: Is there an alternative to the size requirement for the qualifying statement labels for cured pork products?

Answer: Yes. An alternative to the 3/8 inch letter size requirement is that the qualifying statement must be at least 1/3 the size of the common and usual name in the same color and style print as the product name and on the same color background.

29. Question: Must products be labeled the full length of the product with a qualifying statement?

Answer: No.

30. Question: Since PFF accounts for all added substances in a cured pork product, is there any need to limit the use of liquid or solid sweeteners added to chopped ham.

Answer: No.

III. SAMPLING

31. Question: What does the term "periodic" mean as it applies to the sampling rate?

Answer: "Periodic" sampling means sampling at a rate other than daily. All plants start in periodic sampling.

32. Question: At what point in the process is a PFF product to be sampled?

Answer: When it is ready to enter commerce, e.g., as a finished consumer ready unit.

33. Question: Does an entire ham need to be taken as a sample?

Answer: A complete consumer ready unit is necessary for sampling. If that is an entire ham, an entire ham will be used as the sample. Alternative sample preparation may be used at the processors request, provided the equipment necessary for preparing the sample is available at the plant, that is,

selecting a consumer ready unit, comminuting the unit, mixing the comminuted sample and selecting a one pound unit of the comminuted sample, under the inspector's supervision.

34. Question: Can a center slice be used as the sample unit?

Answer: Yes, but only when a center slice is being sold as the consumer unit. Since the minimum sample size submitted to the laboratory is one pound, more than one center slice may be needed.

35. Question: When the sample request directs the inspector to sample the product "ham",in a plant that produces whole hams, center slices, butts, or shank portions from the same lot, what product does the inspector sample?

Answer: All products (hams, shank portions, butt portions, and slices) produced on one shift are treated as one lot for sampling purposes and the sample units selected are randomly chosen, regardless of their form, +[unless the plant has a letter on file as per Question 103, page 21.]+

36. Question: Can the inspector take more samples during periodic sampling at the processors request?

Answer: No.

37. Question: Does the computer make a determination as to which product will be sampled?

Answer: Yes, but with alternatives from the same Group. In the event the products or alternatives are not available, the forms are returned to +[the Regional Office]+ and products from other Groups are not sampled.

38. Question: If only a partial lot is available for sampling, are the results of the sampling included in the determination of the Group/Product Values?

Answer: Yes.

39. Question: Does a sample represent all of the product produced in all Groups?

Answer: No. During periodic and daily sampling, it represents all products from the group from which it was selected.

40. Question: Is sampling increased during holiday periods?

Answer: Sampling rates are based on sample results, -- good results mean less sampling, bad results mean more sampling; however, production volume does affect sampling frequencies.

41. Question: For sampling purposes, should processors be encouraged to grind their samples rather than submitting a whole product unit as a sample?

Answer: No.

42. Question: Are plants allowed to devise a sampling plan for the retention phase which is different than the one which is included in the regulation?

Answer: Yes. The sampling plan must be as effective as the one specified in the regulation and must be approved by the Administrator prior to its use during the retention phase.

43. Question: Is a Group Value maintained for ham patties?

Answer: Yes. All products under the purview of this regulation will have a Group Value and a Product Value.

44. Question: Is a steam cooked product placed in the same Group as water cooked product?

Answer: Yes, if they are packaged +[in the same manner.]+

45. Question: If a processor is producing a boneless cooked ham in an impervious casing, is it considered to be a Group I product?

Answer: Yes. Any product which is imperviously encased, is a Group I product no matter whether it is canned, in an impervious nylon casing, or in a plastic cook-in bag, boneless or bone-in.

46. Question: If one product goes into retention, can it be removed from the Group and monitored separately?

Answer: Yes. If the average production rate of the product over the 8-week period preceeding the week in which the retention occurred, is not greater than 20% of the rate of production of its Group.

47. Question: Can the inspector take action based on Product or Group Value results without input from the computer?

Answer: No. The inspector is not expected to keep track of the Product Values or the Group Values and does not take any action on Product Values or Group Values unless requested by the computer.

48. Question: If a processor keeps track of the Product Values and the Group Values, can the processor determine when retention of any given product is coming?

Answer: Yes. It is recommended that the processor keep informed of the Product Values and the Group Values, as determined by FSIS.

49. Question: If the processor maintains Group Value and Product Value charts with or without computer assistance, should the inspector use the processor's charts?

Answer: No.

50. Question: If a processor is producing several Groups of products and one Group goes into daily or retention phase sampling, how does this affect the sampling of the other Groups?

Answer: It does not.

51. Question: Does the inspector do any calculations associated with PFF compliance?

Answer: Yes. In plant using accredited laboratories, the inspector is expected to determine the PFF of the sample, and determine if the PFF of the sample is equal to or below the Absolute Minimum PFF. The inspector also determines the lot average PFF on retained lots and compare them to the applicable standards to determine if the retained product may be released or if it needs to be reprocessed or relabeled.

52. Question: What does "like product" mean?

Answer: "Like product" is product within the same group, meeting the same PFF standard, and bearing the same common and usual name.

53. Question: Are all boneless hams, even though the boneless hams may represent different quality levels, net weights, and brand names, considered to be a single product?

Answer: Yes. All products which are in the same Group and labeled with the same common and usual name are considered "like product."

54. Question: Can two samples be collected from the same group on the same day?

Answer: No. +[Except during retention sampling.]+

IV. RETENTION

55. Question: If a product is in retention and the Product Value is equal to or greater than zero, and all other parameters for getting out of retention are satisfied, but the variability of the process is still high, will the product remain in retention?

Answer: No.

56. Question: If a regular ham was found to be out of compliance with the standard and retention was initiated, does it affect the compliance of the water added hams?

Answer: No.

57. Question: Are the three samples taken during retention (to determine the lot average PFF) analyzed for PFF independently or will they be a composite sample?

Answer: Independently and results averaged.

58. Question: Is the variability among the three separate samples from the retained lot evaluated and used?

Answer: No.

59. Question: How are the three samples taken from retained lots evaluated?

Answer: The average of the three samples are used for determining the disposition of the lot. The average is entered into the appropriate Product and Group Value calculations. The PFF analyses of the individual samples are compared to the Absolute Minimum requirement, and utilized to determine when the product returns to daily +[or periodic]+ sampling.

60. Question: During retention, does the five lot minimum reflect five days' production or five shifts' production?

Answer: Five consecutive shifts.

61. Question: Once the inspector has determined that the sample PFF is equal to or less than the Absolute Minimum, does the inspector begin retention activities?

Answer: Yes. In addition, the inspector has the responsibility to retain product.

62. Question: If a processor produces both canned ham and regular smoked ham and one of the two goes into retention, are they both placed under retention?

Answer: No. These two products belong to different groups as defined by the regulation and the retention of one does not cause the retention of the other.

63. **Question:** What happens when the PFF of a sample is equal to or less than the Absolute Minimum?

Answer: The lot which is represented by the sample is retained and each subsequently produced lot of like product is placed under retention. The average PFF of each lot is determined and a decision is made to release, reprocess or relabel product. +[At the same time, the group should be placed in Daily Sampling.]+

64. **Question:** During retention of a product with four labels, how does the inspector sample the products? Is product with each of the four labels sampled?

Answer: Three samples are randomly selected under the retention phase. Therefore, all labels may not be sampled.

65. **Question:** If a processor's product goes into retention, can the PFF result (a single sample) that triggered the retention be the basis for calculating the shrink needed to bring the lot into compliance?

Answer: +[No.]+ Once retention is triggered, a three sample average is necessary to determine an accurate lot average PFF upon which to base the decision on the disposition of the product; however, sampling alternatives will be considered if shown to be valid.

66. **Question:** How can retained product be released?

Answer: It must be sampled to determine the lot average PFF and may be released only if the lot average PFF is equal to or higher than the standard, otherwise it may be reprocessed until it meets the standard or be relabeled.

67. **Question:** If a retained lot has been sampled and one of the three samples is below the Absolute Minimum, but the lot average PFF equals the standard, can the lot be released?

Answer: Yes. Compliance of the retained lot is based upon the lot average PFF as determined by the three sample average. The three sample average must be equal to or higher than the applicable standard. However, the sample which is equal to or less than the Absolute Minimum could delay the return to the daily and periodic sampling phases from the retention phase.

68. Question: If canned ham is retained, can it be reprocessed or relabeled?

Answer: Yes.

69. Question: If a plant has a product that goes into retention, can the lot size then be reduced while the product is in retention status?

Answer: No. Lot sizes while in retention status must be substantially the same as they were prior to retention. The purpose of retention status is to make necessary process changes and demonstrate reestablishment of process control. If lot sizes are different, they are not representative of the process in question.

70. Question: Can the results from one sample put the plant into retention?

Answer: Yes, if that Sample PFF Value is equal to or less than the Absolute Minimum or if the Sample Value causes the Group Value and Product Value to fall below the Action Limits.

V. ADDED PROTEINS

71. Question: How are the added proteins identified as added proteins?

Answer: By the inspector in the plant knowing about the addition of the protein containing ingredients and reporting them to the laboratories.

72. Question: How is the meat protein content of an additive determined when the inspector cannot determine the protein content of the additive?

Answer: The inspector informs the laboratory of the quantity of the additive used and that the protein level is unknown. The laboratory deducts the highest amount of protein which is known to exist in the additive being used.

73. Question: If the protein content of an additive varies; or an additive is reformulated to include more or less protein than the original formula, how does the inspector know which level of protein to report to the laboratory?

Answer: The processor is responsible for notifying the inspector if the protein content changes. The inspector informs the laboratory of the additive and the percentage content of protein. In addition, the inspector may request the laboratory to do a protein analysis on the pickle.

74. Question: If 0.5% protein is added to a cured pork product, is 0.5% protein deducted from the total protein to obtain the meat protein used in calculating the PFF?

Answer: All non-meat proteins are deducted on a finished product basis. Although unlikely, more than 0.5% may be deducted if the finished product yield is less than the green weight.

75. Question: If a protein-containing ingredient is used in a cured pork product and the label of the ingredient includes a statement as to the percent protein contained in the ingredient, is the label statement accepted as a declaration of protein content?

Answer: Yes, but that does not mean the inspector may not occasionally sample.

76. Question: If the processor does not use any protein additives, should the inspector note smokehouse and cooler shrink on the sample request form?

Answer: No.

77. Question: Are plants required to certify the amount of protein in added ingredients?

Answer: No. The inspector records the amount of the added ingredients containing proteins used in the products and the percent of protein found in the added ingredient if it is available. If the the amount of protein in the added ingredient is not available to the inspector, the laboratory deducts the maximum percent of protein normally found in that ingredient.

78. Question: How are protein-containing flavorings added to curing solutions detected by the compliance system and subtracted from the total protein to provide the meat protein content?

Answer: All additives which contain protein--including flavorings--are reported to the laboratory by the inspector and noted on the sample request form so that they may be deducted from the total protein as added proteins. Sampling of additives in a pickle may occasionally be necessary.

79. Question: Is any credit for the loss of protein during cooking allowed by the PFF regulation?

Answer: No.

80. Question: Are substances such as pork broth, dried beef stock, etc., which are added for flavor or to enhance flavor, permitted in PFF controlled products?

Answer: Yes. However, the protein contributed by such ingredients is deducted when determining the PFF value.

81. Question: Is a cured pork product that is subject to the PFF regulation but contains poultry regulated under PFF?

Answer: Yes. The protein contributed by the poultry +[which is added for meat]+ is not deducted to determine the PFF.

82. Question: Is collagen or other proteinaceous material, used for any purpose such as an outer wrapping or coating, deducted as an added meat protein?

Answer: Yes.

VI. QUALITY CONTROL

83. Question: Can a quality control (QC) program be established in a plant without having a QC laboratory in the plant?

Answer: Yes.

84. Question: How often is sampling of products required in a QC program?

Answer: There has not been any establishment of guidelines on the frequency of sampling in a PFF QC program. Sampling frequencies must take into account such things as type of in-process controls, volume, variability, product lines, etc.

85. Question: How is the X in the X% product controlled?

Answer: By formulation and yield, i.e., in-plant control. However, laboratory analysis may supplement the control program. At a later date if laboratory analysis can be effective, it will be considered.

86. Question: If a product was labeled as "'X%' of weight is added ingredients," is variation allowed around the "X%".

Answer: Some variation around the "X%" is allowed.

87. Question: Are guidelines on the preparation of a PFF QC program available for use and distributed to industry?

Answer: Yes. Copies are available from the regional offices.

88. Question: Is a processor who has an approved QC program included in the FSIS monitoring system specified in the PFF regulation?

Answer: No.

89. Question: Can the yield data be used as part of the process control rather than the compliance system established by the regulation?

Answer: Yes, if it is part of an approved QC program. Occasional verification sampling will be necessary.

90. Question: Are the control methods used in the PFF regulation adequate for use in a QC program?

Answer: No. The approaches used in the PFF regulation would be acceptable for use in the TQC system or a PQC program, but the system used in the PFF regulation is a monitoring system and not a control system. So, a QC program which mimics the PFF regulation is not adequate to control a process and is not acceptable.

91. Question: Who handles sampling for a TQC plant?

Answer: The plants, with one exception, i.e., the inspector may select verification samples to monitor the QC activity.

92. Question: Can data collected on past production be used to document the adequacy of a QC system or program?

Answer: Yes, if the process is unchanged.

VII. LABORATORIES

93. Question: If a yield test indicates the product is in compliance, but the laboratory results indicate that the product is not in compliance, which result takes precedence?

Answer: The laboratory result takes precedence under the PFF compliance system.

94. Question: Are processors allowed to use accredited laboratories for fat and protein analyses?

Answer: Yes.

95. Question: Do inspectors receive results from the accredited labs?

Answer: Yes. The information flow between the inspector and the accredited labs has not changed.

VIII. IMPORTS

96. Question: Are imported products subject to the same PFF standards?

Answer: Yes.

IX. EXEMPTIONS

97. Question: Are cured pork products prepared under custom exemption subject to the PFF regulation?

Answer: No, because these products do not carry the mark of inspection.

98. Question: Are cured pork products prepared under retail exemption subject to the PFF regulation?

Answer: No, because these products do not carry the mark of inspection.

X. STATE PROGRAMS

99. Question: How does the PFF regulation affect state inspected plants?

Answer: All cured pork products produced in state plants must comply with the PFF standards.

100. Question: Is a state plant a part of the PFF directed sampling and compliance system?

Answer: Yes, unless they have an approved QC program.

XI. OTHER

101. Question: Do processors need to continue submitting processing procedures for cured pork products to the inspector as they have under the current regulation?

Answer: Yes. The inspector must have the processing procedures to monitor the use of restricted ingredients and processing procedures.

102. Question: How are Talmadge-Aiken plants treated under the PFF regulation?

Answer: The same as any other federally inspected plant.

XII. NEW STATEMENTS

+[103. Question: May a processor elect to base their PFF program on the unportioned finished product before it is portioned and packaged?

Answer: Yes. The processor must issue a letter to this effect alerting the FSIS program employee of its desire so that sampling will be done in an appropriate manner.]+

TABLE TO DETERMINE X% ON RETAINED PRODUCT LABEL WHEN FAT AND PFF ARE KNOWN

	PFF													
%FAT	10.0	10.5	11.0	11.5	12.0	12.5	13.0	13.5	14.0	14.5	15.0	15.5	16.0	16.5
UP TO														
0.5	35	35	35	35	30	30	30	30	25	25	25	25	20	20
3.5	35	35	35	35	30	30	30	30	25	25	25	20	20	20
4.0	35	35	35	30	30	30	30	30	25	25	25	20	20	20
8.5	35	35	35	30	30	30	30	25	25	25	25	20	20	20
9.0	35	35	30	30	30	30	30	25	25	25	25	20	20	20
10.0	35	35	30	30	30	30	30	25	25	25	20	20	20	20
13.0	35	35	30	30	30	30	25	25	25	25	20	20	20	20*
15.5	35	30	30	30	30	30	25	25	25	25	20	20	20	20*
16.5	35	30	30	30	30	25	25	25	25	25	20	20	20	20*
17.0	35	30	30	30	30	25	25	25	25	20	20	20	20	20*
20.5	30	30	30	30	30	25	25	25	25	20	20	20	20	20*
22.0	30	30	30	30	25	25	25	25	25	20	20	20	20	20*
22.5	30	30	30	30	25	25	25	25	25	20	20	20	20*	20*
25.0	30	30	30	30	25	25	25	25	20	20	20	20	20*	20*
28.0	30	30	30	25	25	25	25	25	20	20	20	20	20*	20*
28.5	30	30	30	25	25	25	25	20	20	20	20	20	20*	20*
29.5	30	30	25	25	25	25	25	20	20	20	20	20	20*	20*
32.0	30	30	25	25	25	25	25	20	20	20	20	20*	20*	20*
32.5	30	25	25	25	25	25	25	20	20	20	20	20*	20*	20*
35.5	30	25	25	25	25	25	20	20	20	20	20	20*	20*	20*
36.5	25	25	25	25	25	25	20	20	20	20	20*	20*	20*	20*
40.5	25	25	25	25	25	20	20	20	20	20	20*	20*	20*	20*
41.0	25	25	25	25	20	20	20	20	20	20	20*	20*	20*	20*
43.5	25	25	25	25	20	20	20	20	20	20*	20*	20*	20*	20*
45.0	25	25	25	20	20	20	20	20	20	20*	20*	20*	20*	20*
45.5	25	25	25	20	20	20	20	20	20	20*	20*	20*	20*	20*
46.5	25	25	25	20	20	20	20	20	20	20*	20*	20*	20*	20*
49.0	25	25	20	20	20	20	20	20	20*	20*	20*	20*	20*	20*
50.0	25	20	20	20	20	20	20	20*	20*	20*	20*	20*	20*	20*

*This indicates that the actual value determined is less than the value given but 20% is the least value allowed on an X% label.

PFF CURED PORK PRODUCTS

PRODUCT CODE	MINIMUM PFF VALUE	DESCRIPTION
01	20.5	Ham, Heat Treated
02	18.5	Ham/Natural Juices, Heat Treated
03	17.0	Ham/Water Added, Heat Treated
04	20.5	Loin, Heat Treated
05	18.5	Loin/Natural Juices, Heat Treated
06	17.0	Loin/Water Added, Heat Treated
07	20.0	Shoulder, Heat Treated
08	18.0	Shoulder/Natural Juices, Heat Treated
09	16.5	Shoulder/Water Added, Heat Treated
10	20.0	Butt, Heat Treated
11	18.0	Butt/Natural Juices, Heat Treated
12	16.5	Butt/Water Added, Heat Treated
13	20.0	Picnic, Heat Treated
14	18.0	Picnic/Natural Juices, Heat Treated
15	16.5	Picnic/Water Added, Heat Treated
16	19.5	Spiced/Pressed/Chopped Ham, Heat Treated
17	17.5	Spiced/Pressed/Chopped Ham/Natural Juices, Heat Treated
18	16.0	Spiced/Pressed Chopped Ham/Water Added, Heat Treated
19	20.5	Ham Shanks, Heat Treated
20	18.5	Ham Shanks/Natural Juices/Heat Treated
21	17.0	Ham Shanks/Water Added, Heat Treated
25	19.5	Patties, Heat Treated
27	17.5	Patties/Natural Juices
28	16.0	Patties/Water Added
26	18.0	Ham, Not Heat Treated
44	18.0	Ham Shanks, Not Heat Treated
29	18.0	Loin, Not Heat Treated
32	17.5	Shoulder, Not Heat Treated
35	17.5	Butt, Not Heat Treated
38	17.5	Picnic, Not Heat Treated
51	00.0	No Alternate Product Available

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE | 7110.3 | 5-12-88

TIME/TEMPERATURE GUIDELINES FOR COOLING HEATED PRODUCTS

I. **PURPOSE**

This directive transmits updated time and temperature guidelines for cooling heated products.

II. **CANCELLATION**

MPI Manual, Part 8.55(e), cooling provisions (last four sentences).

III. **[RESERVED]**

IV. **REFERENCES**

MPI Regulations, Sections 318.17 and 381.149.

V. **POLICY**

The attached time and temperature guidelines are to be used in conjunction with applicable regulations in meat and poultry processing establishments.

Deputy Administrator
Meat and Poultry Inspection Operations

Attachment
Time/Temperature Guidelines for
Cooling Heated Products

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

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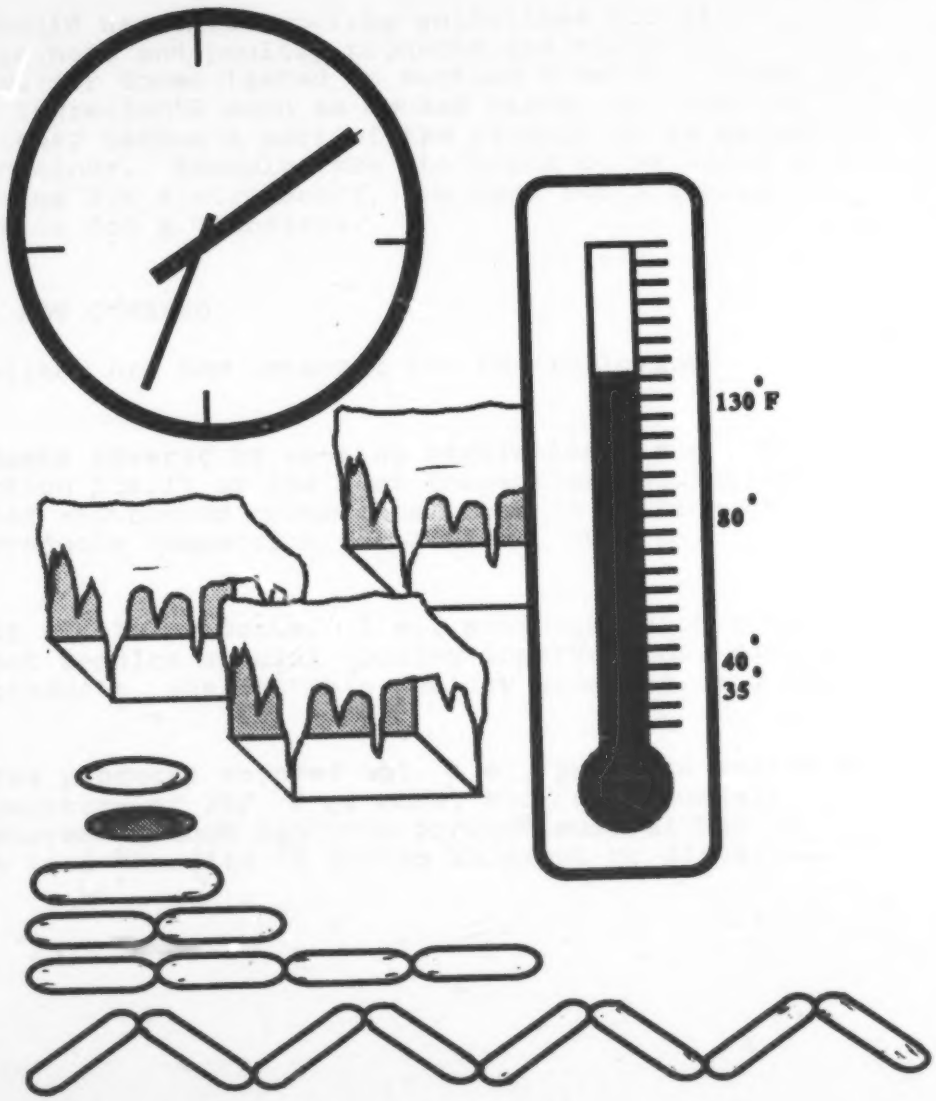
United States
Department of
Agriculture

Food Safety
and Inspection
Service

Technical
Services

Processed
Products

Time/Temperature Guidelines for Cooling Heated Products



TIME/TEMPERATURE GUIDELINES FOR COOLING HEATED PRODUCTS

THE SHORT VERSION

I. COVERAGE

A. COVERED PRODUCTS

Processors should use these cooling guidelines for all heated, perishable meat and poultry products and their ingredients except for those listed in Section B below. These guidelines cover ingredients such as cooked beans, noodles, or rice which may either become a part of the product or be packed in a separate container. Examples are the beans to be added to a burrito, the noodles for a stroganoff, the peas for a frozen dinner, and the rice for a jambalaya.

B. PRODUCTS NOT COVERED

These guidelines are not intended for the following products:

1. **Products covered by cooling regulations**, e.g., those specified in Section 318.17 of the Meat Inspection Regulations, such as roast beef and cooked corned beef, and in Section 381.149 of the Poultry Products Inspection Regulations, such as canned poultry.

2. **Shelf stable products**, i.e., products which after processing, do not require special cooling instructions, such as fully retorted products, shelf-stable semidry sausages, and dry cured hams.

3. **Cooked products shipped hot**, i.e., products heated to an internal temperature of 155 °F or more, and conspicuously labeled with a statement such as "This product must either be maintained at no less than 140 °F during shipment or discarded."

II. RECOMMENDED COOLING RATES FOR HEATED PRODUCTS

A. RAPID COOLING.

To avoid product adulteration, processors should rapidly and continuously cool all products not included in Section B below. To rapidly cool, processors should meet the cooling rates below.

1. During cooling, the product's maximum internal temperature should not remain between 130 °F and 80 °F for more than 1.5 hours nor between 80 °F and 40 °F for more than 5 hours, except for product described in paragraph II. A. below.

2. Product consisting of pieces of intact muscle, such as turkey breast or pork loin, may be cooled according to the requirements of Section 318.17(h)(10) of the Meat Inspection Regulations.

B. SLOW COOLING FOR SOME CURED PRODUCTS.

Processors may slowly cool cured products if the product satisfies condition 1, one of the two choices in condition 2, and one of the three choices in condition 3 below.

1. The internal temperature does not remain between 120 °F and 40 °F for more than 20 hours; and

2. the cooling process:

a. causes a continuous drop in product temperature; or

b. controls the product's surface temperature so that it does not stay between 120 °F and 80 °F for more than 2 hours; and

3. the product is formulated:

a. with no less than 120 ppm of sodium nitrite or its equivalent (e.g. 148 ppm KNO_2 and a brine concentration of 3.5 percent or more; or

b. with no less than 40 ppm of sodium nitrite or its equivalent (e.g. 148 ppm KNO_2) and a brine concentration of 6 percent or more; or

c. with or without nitrite (such as salt cured product), but with a maximum water activity of 0.92.

III. HOLDING TEMPERATURES

A. COLD STORAGE TEMPERATURES

35 °F rather than 40 °F should be used to store uncured processed product for any period of time longer than one week.

B. INTERMEDIATE HOLDING TEMPERATURES

These time and temperature guidelines apply to the holding of heated products before cooling them to 40 °F. Products heated above 155 °F then cooled from 130 °F to 60 °F within 2 hours may be held for up to 4 hours if they are:

1. kept below 60 °F during the 4 hours,

2. protected from post-cooking contamination, and

3. cooled to 40 °F within 2 hours, at the end of the 4 hour holding period.

C. HOT HOLDING TEMPERATURES

Uncured cooked products may be safely held for up to 4 hours if kept above 130 °F, or for an extended period if kept above 140 °F. If product drops below 130 °F for over 30 minutes, the processor should either continuously cool it to meet the times and temperatures in II. B. above, immediately reheat it to 160 °F, or discard it.

CAUTION: Processors should hold product above 140 °F unless they have established excellent temperature control over every portion of the product. Thus, processors should definately keep product above 140 °F when it is in transit, in containers without temperature monitoring, and in similar cases where excellent control is not established and maintained.

THE LONG VERSION, INCLUDING

INTRODUCTION
SIGNIFICANT FOOD SAFETY TEMPERATURES
PREMISES FOR COOLING GUIDELINES
COVERAGE
COOLING RATES
HOLDING TEMPERATURES
MONITORING
VARIANCES IN COOLING RATES
ALTERNATE COOLING PROCEDURES
IMPROVING PRESENT COOLING

INTRODUCTION

This Processing Policy Memo contains guidelines for cooling cooked or heated products in a manner that FSIS recognizes as good practice. It also describes how to develop an acceptable alternative cooling control program and how to improve cooling efficiency.

Most cooked foods are not sterile; many spores will survive an hour or more of boiling. In addition to the heat-resistant bacteria which survive cooking, post-cooking contamination is possible even in an environment which appears entirely sanitary. Therefore, processors must cool heated products rapidly if they are to prevent these bacteria from growing and causing problems.

USDA research[1/,2/] has provided new information on cooling rates that will minimize growth of pathogenic bacteria that generally cause problems in slowly cooled foods. The cooling rates are based on that research. However, to safely use these cooling rates, processors need to consistently control the cooling of their products. Lack of control will erode the safety margin in these cooling rates. Maintaining control requires efficient, knowledgeable employees who use the cooling facility and monitor the process carefully. The guidelines thus recommend not only cooling rates, but also processor control.

1) Blankenship, L. R. et. al. (1986) Growth of Clostridium perfringens in chili during post cook chilling. ASM Annual Meeting. Abstract P-28.

2) Blankenship, L. R. et. al. (1988) Applied and Enviornmental Microbiology. In Press.

Significant Food Safety Temperatures

To help the processor understand the basis of these cooling guidelines, FSIS has developed this list of current and traditionally cited temperatures.

35 °F FSIS recommended storage temperature for periods exceeding one week. This storage temperature will greatly reduce the growth of psychrotrophic spoilage bacteria as well as psychrotrophic pathogens such as *Listeria* and *Clostridium botulinum* type B.

40 °F Traditional FSIS recommended maximum storage temperature and control point.

45 °F FDA recommended temperature cooling control point and maximum stroage temperature for retail establishments.

55 °F FSIS poultry and roast beef cooling control point.

80 °F Approximate transition between rapid growth and slower growth of many food-borne pathogenic bacteria; little or no growth of *Clostridium perfringens* below this point.

100 °F Rapid growth of most food poisoning bacteria.

120 °F FSIS cooling control point for roast beef; traditional USDA cooling control point; rapid germination and growth of *C. perfringens*; minimal to no growth of *Staphylococcus aureus*, *C. botulinum*; minimum trichina treatment temperature for cured pork products.

125 °F Upper growth limit for *C. perfringens*.

130 °F FSIS recommended control point; recommended holding temperature for up to 4 hours, minimum cooking temperature for roast beef.

140 °F FDA recommended holding temperature and cooling control point for retail establishments; USDA recommended minimum holding temperature for extended periods, minimum shipping temperature.

155 °F FSIS recommended minimum cooking temperature for a product which is to be shipped hot.

FSIS has based these cooling guidelines on several premises:

1. Heat-resistant food-poisoning bacteria can grow from 38°F up to approximately 125°F; however, their range of rapid growth is from approximately 80 °F to 125°F. Thus, cooling product quickly through the rapid growth range is more important than cooling through the slow growth range.

2. The rate of heat transfer (cooling rate) from the product's center to its surface is directly proportional to the difference in temperature (dT or delta T) between those two points. Thus, as the product temperature approaches the coolant temperature, the cooling rate diminishes.

3. Traditional cured products, containing high amounts of salt and nitrite, together with low moisture content are more resistant to bacterial growth than similar newer products; some are even shelf-stable. Thus, rapid cooling of these traditional products is not always necessary. However, manufacturers are making fewer products of this type today. Instead, to meet present consumer tastes, most of their cured products contain less salt and more moisture. These changes minimize the inhibitory effect of added nitrite and increase the need to rapidly cool these products.

4. If the cause of a small problem, such as a cooling variance, is not traced and corrected when first noticed, the problem will probably recur and grow more severe, until it becomes a disaster resulting in widespread illness among the public and large financial losses for the manufacturer.

5. Clearly written employee instructions are valuable in themselves and as an educational tool for management.

6. A temperature measurement probably represents neither the minimum nor the maximum temperature of a product lot because (a) the temperature is not the same throughout the lot, and (b) the temperature measuring device conducts heat better than the product. Processors can minimize these errors by (a) measuring more than one piece of product and (b) using thin temperature probes and shielding or insulating the part exposed to the coolant.

7. The more closely processors operate to the known limits of safety, the more important it is that they control the product temperature well; this in turn requires them to accurately monitor the critical parameters.

To incorporate these principles into a practical guideline, FSIS has:

1. Emphasized the need to quickly cool past the rapid growth range.

2. Acknowledged the relationship between the recommended temperature and the time periods involved,

3. Identified those products that may be cooled more slowly,

4. Listed the responsibilities of processors who wish to use the more liberal cooling rates, and

5. Added safety margins to compensate for inherent errors.

COVERAGE

A. COVERED PRODUCTS

Processors should use these cooling guidelines for all heated, perishable meat and poultry products, and their ingredients, except for those listed in Section B below. These guidelines cover ingredients such as cooked beans, noodles, or rice which may either become a part of the product or be packed in a separate container. Examples are the beans to be added to a burrito, the noodles for a stroganoff, the peas for a frozen dinner, and the rice for a jambalaya.

B. PRODUCTS NOT COVERED

These guidelines are not intended for the following products:

1. **Products covered by cooling regulations,** i.e., those specified in Section 318.17 of the Meat Inspection Regulations, such as roast beef and cooked corned beef, and in Section 381.149 of the Poultry Products Inspection Regulations, such as canned poultry.

2. **Shelf stable products,** i.e., products which after processing, do not require special cooling instructions, such as fully retorted products, shelf-stable semidry sausages, and dry cured hams.

3. **Cooked products shipped hot,** i.e., products heated to an internal temperature of 155 °F or more, and conspicuously labeled with a statement such as "This product must either be maintained at no less than 140 °F during shipment or discarded."

II. RECOMMENDED COOLING RATES FOR HEATED PRODUCTS

A. RAPID COOLING.

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2. Product consisting of pieces of intact muscle, such as turkey breast or pork loin, may be cooled according to the requirements of Section 318.17(h)(10) of the Meat Inspection Regulations.

B. SLOW COOLING FOR SOME CURED PRODUCTS.

Processors may slowly cool cured products if the product satisfies condition 1, one of the two choices in condition 2, and one of the three choices in condition 3 below.

1. the internal temperature does not remain between 120 °F and 40 °F for more than 20 hours

2. the cooling process

   a. causes a continuous drop in product temperature

   b. controls the product's surface temperature so that it does not stay between 120 °F and 80 °F for more than 2 hours

3. the product is formulated

   a. with no less than 120 ppm of sodium nitrite or its equivalent and a brine concentration of 3.5 percent or more

   b. with no less than 40 ppm of sodium nitrite or its equivalent and a brine concentration of 6 percent or more

   c. with or without nitrite (such as salt cured product), but with a maximum water activity of 0.92.

III. HOLDING TEMPERATURES

A. COLD STORAGE TEMPERATURES

35 °F rather than 40 °F should be used to store uncured processed product for any period of time longer than one week.

B. INTERMEDIATE HOLDING TEMPERATURES

These time and temperature guidelines apply to the holding of heated products before cooling them to 40 °F. Products heated above 155 °F then cooled from 130 °F to 60 °F within 2 hours should remain unadulterated for up to 4 hours if they are:

1. kept below 60 °F during the 4 hours,

2. protected from post-cooking contamination, and

3. cooled to 40 °F within 2 hours, at the end of the 4 hour holding period.

C. HOT HOLDING TEMPERATURES

Uncured cooked products may be safely held for up to 4 hours if kept above 130 °F, or for an extended period if kept above 140 °F. If product drops below 130 °F for over 30 minutes, the processor should either continuously cool it to meet the times and temperatures in II. B. above, immediately reheat it to 160 °F, or condemn it. **CAUTION:** Processors should not attempt to hold product below 140 °F unless they have established good temperature control over all portions of the product. Thus, processors should keep product above 140 °F when it is in transit, in containers without temperature monitoring, or in similar cases where good control is not established and maintained.

IV. MONITORING

To safely use these more flexible cooling rates, processors must accurately monitor the product's internal temperature. FSIS suggests that temperature recorders are generally the best and most economical means. Additional recommendations for temperature monitoring follow:

A. THE MONITORING DEVICE

1. **Accuracy:** The temperature recording devices should be both readable and accurate to 2 °F and 5 minutes within the critical range. The processor should check the manufacturer's accuracy specifications before purchasing a unit, e.g., a unit accurate within 1 percent of range and a range of 0 °F to 250 °F is not accurate enough. However, a processor can verify that some of these instruments are in fact sufficiently accurate by careful calibration at two temperatures within the critical temperature range. (See subparagraph 2. below.)

2. **Calibration:** Processors should check each new instrument for accuracy regardless of the manufacturer's claims; rough handling during shipping can undo the factory calibration. Although electronic instruments are resistant to rough handling, they too should be checked. The processors should calibrate both time and temperature accuracy against known standards.

a. Temperature calibration standards: The most practical and reliable temperature standard for this purpose is a mercury-in-glass thermometer which conforms to the standards of the American Society for Testing Materials (ASTM). In most cases ASTM requires that thermometers bearing their initials be accurate within one scale division.

A review of ASTM Standard E-1, Standard Specification for ASTM Thermometers, will present the processor with a choice of several ASTM thermometers having a maximum scale error of less than 20 °F. The ASTM 64 F thermometer would be an excellent choice for calibrating in the range of 80 to 130 °F. The ice point at 32 °F is a reference point for temperature calibration and is used to detect changes in the reading of the standard mercury-in-glass thermometer due to changes in the volume of the bulb with time.

b. Calibration procedure: Immerse the probe and standard into a substance with a uniform temperature; FSIS recommends a stirring water bath within 20 °F of the critical temperature the measuring device will have to monitor. For these cooling guidelines, a water bath at 105 °F would suffice, however, calibrating the device at two temperatures within the 130 °F and 80 °F range is better.

c. Verifying the accuracy of uncertified thermometers: A processor with a thermometer that the manufacturer does not certify to be accurate within 2 °F and 5 minutes may be able to verify that it is adequate by checking it at several standard temperatures within the critical temperature range. For these cooling guidelines, FSIS recommends verifying that the measured temperatures at 130 °F, 80 °F, and 40 °F are accurate.

B. TEMPERATURE MEASUREMENT

1. **Number of probes:** The number of probes or temperature sensing devices needed varies with the circumstances. Processors should depend on their QC resources to determine the appropriate number and placement.

2. **Frequency of monitoring:** Initially the plant should monitor every lot. However, if the plant builds a history of excellent compliance, reduced monitoring should not add unacceptable risk. Processors should consult with their QC specialists for applications to their specific plant.

C. RECORDS

Processors should keep records of all time and temperature checks for at least 1 year, even though the product may have a shelf-life of only 60 days. A record of good manufacturing practice is valuable insurance, and an invaluable reference for improving future performance.

V. VARIANCES IN COOLING RATES

These guidelines contain a safety margin; therefore, a small lapse in and of itself will probably not cause a problem in every instance. However, a large variance or continual small ones constitute unacceptable risk. In addition, the processor should consider an occasional small variance an opportunity to find and correct a control problem.

A. UNACCEPTABLE VARIANCES

If the number of minutes of product cooling time exceeds the minutes of guideline time by more than 25 percent, the processor should take the following actions:

1. Notify the inspector, the QC unit, and other concerned units such as refrigeration maintenance and production.

2. Hold the involved product and examine it for potential adulteration by bacteria, particularly clostridial pathogens. If it is adulterated, inform the inspector.

3. Postpone further product manufacturing utilizing that chill facility until the processor has:

   a. determined the cause of the variance;

   b. completed adjustments to assure that the variance will not recur; and

   c. informed the inspector and the production units of the determinations and adjustments and made any needed amendments in the written processing procedures.

If the number of minutes of product cooling time exceeds the minutes of guideline time by any percentage twice or more in any consecutive 20-day-period of production, the processor should take the following actions:

1. Notify the inspector, the QC unit, and other concerned units such as refrigeration maintenance and production.

2. Postpone further product manufacturing utilizing that chill facility until the processor has:

   a. determined the cause of the variance;

   b. completed adjustments to assure that the variance will not recur; and

   c. informed the inspector and the production units or the determination and adjustments and made any needed amendments in the written procedures.

B. OTHER VARIANCES

If the actual cooling time exceeds a guideline time by less than 25 percent once during any 20-consecutive-day period of production, the processor should:

1. Notify the inspector, the QC unit, and other concerned units such as refrigeration maintenance and production;

2. Investigate and determine the cause of the variance;

3. Complete any needed adjustments to assure that the variance will not recur;

4. Inform the inspector and production unit of the determinations and adjustments; and

5. Make any needed amendments in the written processing procedures.

READEX FICHE best copy available

VI. ALTERNATE COOLING PROCEDURES

Processed Products Inspection Division based these guidelines on the best available information and is providing them for general application. We will modify the general guidelines if we have additional information to warrant it. In addition, Processed Products Inspection Division will consider alternate cooling procedures which processors may propose for their specific products and processes.

A. BASIS FOR ACCEPTABLE ALTERNATE PROCEDURES Acceptable alternate procedures should be based on reliable information that assures the safety of the procedure. Either:

1. **Original scientific research**, developed from a previously accepted research protocol, which establishes the safety of the alternate procedure with respect to the probable pathogens concerned and identifies the critical factors; or

2. **A letter or report by a processing authority** that the proposed procedure is appropriate for the product proposed, considering the processing method, the packaging method, the handling involved, and the pathogens considered. This should be supported by an appropriate review of the relevant scientific literature and any original data.

B. CONTENT OF ACCEPTABLE ALTERNATE PROCEDURES Acceptable alternate cooling procedures should include:

1. A description of the cooling procedure, including:

   a. The critical control points

   b. A map of the cooling facility and the product arrangement within it

   c. A description of the cooling facility's refrigeration capacity and coolant flow

2. An explanation of how the plant will control the procedure, including:

   a. A product temperature monitoring program that is at least equal to that in Division IV of this guideline

   b. The product processing procedure including controls over product formulation and composition

   c. How the critical control points will be controlled

   d. Written employee instructions as to how cooling is to be done, how monitoring is to be done, and how variances should be handled.

VII. IMPROVING PRESENT COOLING

We have added this Division to the Guidelines to help processors consistently satisfy our recommended cooling rates, thus producing higher quality products and also saving energy and the money that energy represents. We have based the following information on our experience with solving cooling problems and the scientific expertise of the USDA's Agricultural Research Service.

A. COMMONLY KNOWN FACTS ABOUT COOLING

Some of the means for improving product cooling are commonly known because we all are continually exposed to some form of cooling; winter winds, metal stadium seats, or cold swimming pools are some of the examples. We have also learned to minimize the chilling effects of these factors by standing out of the wind, sitting on cardboard, or wearing a wetsuit. But we don't always apply what we know in one context to another. Thus, we have devised this Division to stimulate processors to apply their present knowledge to improving food cooling. We have also included two simplified formulas to aid in quantifying the effect of different cooling practices and added a cooling practice checklist.

B. HEAT FLOW

Processors planning cooling improvements should consider how heat moves from the product's center to it's surface and ultimately to the exterior of the plant. A simplified diagram would be:

```
[PRODUCT] [PRODUCT]                    [REFRIGERATOR][REFRIGERATOR]
[CENTER]->[SURFACE]->[COOLANT]->[EVAPORATOR]->[CONDENSER]->[AIR]
                                    [COIL]       [COIL]
```

The rate at which heat flows between these preceding steps is governed by the laws of heat transfer. By understanding the gist of these laws, and applying them to cooling procedures, the processor can improve cooling efficiency.

C. PHYSICAL LAWS OF HEAT TRANSFER

1. **Fourier's and Newton's Laws** describe the factors affecting heat transfer from the food product until it is ultimately transferred to the outside environment. Understanding these laws will help you understand how to improve your cooling rate.

A simple expression of Fourier's law of heat transfer is:

$$q = \frac{k \times A \times dT}{L}$$

Newton's Law of cooling by convection is:

$$q = h \times A \times dT$$

q is the rate of heat transfer (BTU/hr)

k, for Fourier's Law, is the thermal conductivity constant (ice is 1.28; cold water is .32; meat is .29; stainless steel is 9.4)

h, for Newton's Law of Convection, is the heat transfer coefficient (still air = 0.5 to 5; fanned air = 2 to 20; stirred water = 100 to 1000)

A is area for heat transfer (sq ft)

dT, in Fourier's Law, is the difference in temperature between the surface and center (^{o}F) or in Newtons's Law, the difference in temperature between the food and coolant

L is the distance the heat must move (ft)

2. To better understand what these laws mean to you, imagine what would happen if you tried the following experiments:

a. The effect of "A" & "L": Take two 5 pound warm meatballs and mash one to 1 inch thickness, net both, then hang them in the same cooler. Experience tells you that the mashed meatball will cool faster; so does Fourier. For the mashed meatball, "A" is higher and "L" is lower, thus q, the rate of heat transfer, will be higher.

The factors are multiplied in Newton's and Fourier's laws. Thus, halving any factor (except "L") halves "q", the rate of heat transfer; halving "L", doubles "q".

b. The effect of "A", "L" & "k": Next, take two identical 5 pound meatballs mashed to 1 inch thickness. Put one on a plastic foam tray, the other on a stainless steel tray, and place both in the same area of the cooler. Because the plastic tray conducts very little heat, it effectively reduces "A" by almost half (the 1 inch edge would remain the same). Conversely, the stainless steel tray conducts heat more rapidly than the air and effectively acts as a large fin, thus "dT" will be higher at the bottom surface of the meat than at the top. Experience reinforces this logic; leaning against a steel wall will chill you faster than leaning against a wooden or plastic foam wall.

c. The effect of "h" & "dT": The coefficient of heat transfer (h) for stirred air is approximately 50 times that for still air; kids huddled around each other while waiting for the bus would agree. Moving the air across the surface replenishes the air heated by the food with colder air, thus keeping "dT" at a high value for both Fourier's and Newton's laws. Fans are cheaper than lowering the cooler temperature. If you already have fans, check to see if all pieces are being exposed to the moving air; you may find some pieces huddled in the wind shadow of others, exposed only to preheated slow air. Another example of "h" is cold water and air; putting your hand into 50 ^{o}F water chills it much faster than putting it into 50 ^{o}F air. This is not surprising since the value of "h" for water is approximately 100 times the value of "h" for air.

d. The effect of "dT": Imagining an experiment for "dT" is hardly necessary since it is common knowledge that the colder the coolant, the quicker the food will cool; you wear heavier coats on colder days. However, consider the magnitude of "dT" and how it affects the cooling rate. A "dT" of 60 ^{o}F provides sufficiently rapid cooling for most purposes. Beyond that the limiting factor is the food's heat conductance; instead of cooling faster, the surface freezes. Since lower cooler temperatures cost more, processors might be able to economize by using coolant at ambient temperature (air or water) to bring the product temperature to within 50-60 ^{o}F of ambient, then moving the product into the cooler. This would also lessen the heat load on the refrigeration system.

e. The effect of "k", "h", "A", & "L": We can bring several of these factors together by considering the cooling of boxed food. Boxing warm food products slows cooling because of several factors: (1) "h" is low because the food inside is exposed to still air, (2) the box adds an extra layer of insulation, thus decreasing "k", (3) many small pieces in a box become one large thermal mass, thus increasing "L" and decreasing "A". Therefore, it is not surprising to find food remaining above 70 ^{o}F a day after putting in into a cooler, if was boxed while still warm. Boxed food can be cooled safely using a sufficiently cold blast freezer; however, removing a BTU of heat with a freezer costs much more than removing it with a cooler. These are factors the plant management should consider.

f. The thermal conductivity constant, "k": This affects both cooling rates and temperature monitoring. One common manifestation of the effect of "k" in food processing is the use of potato nails, aluminum spikes people stick in potatoes to hasten baking time. Because the aluminum conducts heat so much better than the potato, it is almost like cooking the potato from inside and outside at the same time. The principle works on both cooking and cooling and on meat as well as potatoes.

g. The effect of "k" and temperature measurement errors: Ignoring the effect of "k" can induce errors in temperature monitoring if the temperature probe is thick enough to transfer a significant amount of heat. An example of this can be seen by cutting into a roasted piece of meat, longitudinally, through the hole left by a thick temperature probe. The gray area beneath the surface of the meat will follow the hole into the interior of the meat for some distance. The gray area is the meat that has reached approximately 160 - 170 ^{o}F. The temperature probe, because it transfers heat much better than meat, raises the meat temperature around the probe to 160 - 170 ^{o}F in less time. Errors in temperature monitoring occur when the probe shaft conducts heat to the probe tip and raises the probe tip to the critical temperature faster than the meat an inch or so away. The reverse can happen during cooling when the probe shaft transfers heat from the probe tip and causes an erroneously low reading.

Following is a list of practices that can minimize temperature measuring errors induced by "k"; since they have practical limits we suggest processors use them when practical.

(1) Use probes that are as thin as practical; a 1/8 inch diameter probe carries 4 times the heat that a 1/16 inch diameter probe carries; a 1/4 inch diameter probe carries 16 times the heat that a 1/16 inch probe carries.

(2) Use probes whose exposed metal shaft is thermally (not just electrically) insulated from the cooling (or cooking) medium.

(3) Instead of continuous monitoring, insert the probe only when a temperature reading is needed.

C. A COOLING PROBLEM CHECKLIST

1. **The heat transfer coefficient, "h", for the coolant** directly affects the rate of heat transfer. Since the value of "h" for forced convection air is approximately 5 times that of still air, the processor should check the following:

a. Does the cooler/freezer have fans?

b. Is the product exposed to the air or is it in a protective package?

c. Is the air circulating fully around the product or are some pieces protected from the wind?

d. Could the product be cooled by using chilled water or brine? Cold water has an "h" value approximately 50 times that of fanned air.

2. **Maintaining a large difference in temperature (dT)** between the product's center and its surface or the product and the coolant will assure rapid cooling. If the coolant warms significantly during the cooling cycle, then the later cooling stages will be slower and the processor should consider the following:

a. Should additional refrigeration capacity be installed to cool the amount of product being produced?

b. Is the refrigeration unit running optimally? For instance, are all coils clean, are all compressors properly maintained, are there no impediments to refrigerant flow, and is the refrigerant at optimum pressure?

c. Is hot product (>140 ^{o}F) entering the cooler, thus overloading its capacity? If so, could the procedure be safely amended to permit the product to cool longer at ambient temperature before moving it into the cooler?

d. Is the refrigeration space managed effectively: does stacked product divert coolant flow, is the insulation effective, is there excessive traffic through the space, do doors remain open, and could door baffles help?

3. **Although the thermal conductivity constant, "k", for** meat is not high, it is approximately 30 times that of air and over 10 times the "k" value for many packaging materials. Thus, the processor should consider the following:

a. Is the product packaged in an insulating material, e.g. cardboard or plastic foam, before entering the cooler?

b. If the product is inside a thin film packaging material, are there significant air pockets acting as insulators?

c. Is the product directly exposed to the coolant or is there a thin tight film of packaging material between the coolant and the product? If so, the cooling problem may be elsewhere.

4. The area of product exposed to the coolant is another controllable factor.

a. Is the product exposed to the coolant on all sides?

b. Is part of the product covered by material with a low thermal conductivity value, e.g. thick plastic lugs or trays? If so, could they be replaced with materials with a higher "k" value, e.g stainless steel trays and lugs?

5. The longer the path the heat has to travel, the more time it takes. Thus, the processor should consider whether the present facilities are adequate for large products.

a. Can the product size be reduced in one or more dimensions?

b. Is the product being packed together so that it acts as one large piece?

If you have questions or want additional information on developing cooling control programs or improving your present program, please contact FSIS's Processed Products Inspection Division at the following address:

USDA FSIS TS PPID
Room 2159 South Agriculture Bldg.
Washington, D. C. 202050

You may contact us directly by telephone at (202) 447-3840 or address general questions through the FSIS Hotline at 800-535-4555.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7220.1 Rev. 2	8-24-88

STANDARDS AND LABELING DIVISION POLICY MEMORANDA

I. PURPOSE

This directive transmits all current Policy Memoranda issued by the Standards and Labeling Division (SLD) from 001 dated 05/06/80, to 116 dated 07/11/88.

II. CANCELLATIONS

FSIS Directive 7220.1, Revision 1, dated 08/01/86;
Amendment 1, dated 08/06/86;
Amendment 2, dated 08/25/86;
Amendment 3, dated 09/18/86;
Amendment 4, dated 11/13/86;
Amendment 5, dated 12/24/86;
Amendment 6, dated 02/04/87;
Amendment 7, dated 03/18/87;
Amendment 8, dated 04/28/87;
Amendment 9, dated 05/14/87;
Amendment 10, dated 09/03/87;
Amendment 11, dated 09/30/87;
Amendment 12, dated 10/16/87;
Amendment 13, dated 12/17/87;
Amendment 14, dated 02/01/88;
Amendment 15, dated 05/23/88;
Amendment 16, dated 06/22/88;
Amendment 17, dated 07/07/88;
Amendment 18, dated 07/28/88;
Amendment 19, dated 08/12/88.

III. REASON FOR REISSUANCE

To incorporate Amendments 1 through 19 into a consolidated directive.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Mgt., T/A Plant Mgt., Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/SLD

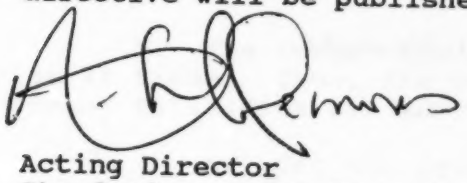
IV. REFERENCES

Federal Meat Inspection Act;
21 U.S.C. 601 et seq.;
Poultry Products Inspection Act;
21 U.S.C. 451 et seq.;
MPI Regulations, Section 317.4, 317.5, 381.132, and 381.134
Standards and Labeling Policy Book

V. ISSUANCE OF POLICY MEMORANDA

The Food Safety and Inspection Services' SLD periodically issues Policy Memoranda concerning significant or novel application or interpretations of the Federal Meat Inspection Act, Poultry Products Inspection Act, the MPI regulations and/or departmental policy. Due to rescissions and cancellations, there are breaks in the sequential numbering order of the memoranda. As a result, the following Policy Memoranda numbers do not appear in this directive: 008, 009, 028, 043, 060, 062, 065, 067, 073, 079.

As new memoranda are issued or previous memoranda are cancelled or superseded, the material will be issued as an amendment to this directive. On a periodic basis, therefore, revisions to this directive will be published to consolidate the amendments.



Acting Director
Standards and Labeling Division
Technical Services

Attachments

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☒ REVISION
☒ AMENDMENTS
☐ OTHER

FSIS Directive Standards and Labeling Division Policy Memoranda	7220.1 Rev. 2 Amend. 1	9-8-88

I. PURPOSE

This document transmits Amendment 1 to FSIS Directive 7220.1, Revision 2.

II. CHANGES

Insert Policy Memos 101A and 117 in numerical order in Attachment 1 of FSIS Directive 7220.1, Revision 2.

III. CANCELLATION

A. Policy Memo 101.

B. This change transmittal is cancelled when contents have been incorporated into FSIS Directive 7220.1, Revision 2.

A. Clemons

Acting Director
Standards and Labeling Division
Technical Services

Attachment

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/SLD

United States Department of Agriculture

Food Safety and Inspection Service

AUG 30 1988

Policy Memo 101A

Branch Chiefs, SLD

Ashland L. Clemons, Acting Director
Standards and Labeling Division
Technical Services

Use of Quality Grade Terms and Subjective Terms on Labels

ISSUE: How and when may terms which denote quality grades and certain other subjective terms be used on labels for meat and/or poultry products?

POLICY: This policy memo supersedes Policy Memo 101. Terms designated as grades of meat, i.e., prime, choice, select, good, etc., may only be used on red meat which has been officially graded. However, the Standards and Labeling Division (SLD) will take no action to rescind currently approved labels which contain the word "select." Labels for new or reformulated products or new product lines will be approved in accordance with the policy for grading terms described above.

Letter grades A, B, C, which are designated grades for poultry may only be used on poultry (whole birds and parts) that are officially graded, and may not be used on red meat. Although poultry grade terms (U.S. Grade A, etc.) are not allowed to be used on red meats, the terms prime, choice and select may be used on poultry (whole birds or parts), that are equivalent to U.S. Grade A. The use of a possessive, e.g., XYZ's Prime, does not relieve a company of this requirement. The use of quality grade terms on further processed meat and poultry products will be evaluated on a case-by-case basis to determine if they wrongly infer that the meat or poultry used in these products has been graded.

Terms which are subjective in nature such as, but not limited to, fancy, finest, super, supreme, ultimate, premium, greatest, best, old fashioned, homestyle, hotelstyle, deluxe, special, famous, and old time may be used unqualified on labels for meat and/or poultry products. The term "selected" as well as other terms, will be considered individually by the Standards and Labeling Division, again to determine if these terms wrongly infer that the meat or poultry has been graded.

RATIONALE: Historically, the Department has allowed the quality grade terms prime and choice to be used on poultry, provided it was the equivalent of U.S. Grade A. Because the new grade term "select" also conveys high quality, its use on poultry should also require that the poultry be equivalent to U.S. Grade A. Poultry grade terms are not allowed on red meats. Policy Memo 101 was in error in this regard.

FSIS 2630-5 (12/79)

As explained in Policy Memo 101, the use of the possessive in conjunction with quality terms was considered unnecessary since terminology such as "best," "premium," etc., has been accepted as nothing more than advertising puffery which neither misleads nor deceives the public. Policy Memo 101 did not make it clear that the use of the possessive in conjunction with meat grading terms was not appropriate for poultry that was not the equivalent of U.S. Grade A. The use of red meat grading terms, although in the possessive, would still imply incorrectly that the poultry has been graded.

In the past, the term "select" was permitted to be used on labels of meat and poultry products as a subjective term without regard to grading. Recently, the official grade term U.S. Good, designated for beef and lamb, was changed to U.S. Select for beef, consequently, the word "select" will no longer be allowed as a subjective term. However, continued use of the term "select" will be allowed for products for which companies have obtained prior approval for labels which include the term "select." Denying these companies the use of the term "select" on these products would place unwarranted economic burdens on these companies through the loss of previous investments in advertising and labeling materials.

United States Department of Agriculture

Food Safety and Inspection Service

AUG 30 1988

To: Branch Chiefs, SLD

Policy Memo 117

From: Ashland L. Clemons, Acting Director
Standards and Labeling Division
Technical Services

Subject: Smoke Flavoring

ISSUE: What are the labeling requirements for products containing a component to which smoke flavoring has been added?

POLICY: The use of smoke flavoring (natural or artificial) in a component of a meat or poultry food product, e.g., ham in a ham salad, does not require that the product name be qualified to indicate the presence of the smoke flavoring. However, the smoke flavoring must be declared in the ingredients statement on the meat or poultry product labels.

RATIONALE: The Meat and Poultry Inspection Regulations, 9 CFR 317.2(j)(3) and 381.119, require that when an approved artificial smoke flavoring or an approved smoke flavoring is added as an ingredient in the formula of a meat and/or poultry food product, the presence of the smoke flavoring must be shown contiguous to the product name and listed in the ingredients statement. The Meat and Poultry Inspection Regulations, however, do not explicitly address whether this requirement applies to smoke flavoring which is an ingredient of a component that is used in a meat food product or poultry food product (secondary product). Because of the absence of clarity in the regulations, confusion and inconsistency in the approval of labeling has resulted over the years.

We see no useful purpose in requiring a qualifying statement in the name of the secondary product. The presence of the smoke flavoring in the ingredients statement will provide the necessary information to those consumers who are interested in knowing if a component has been treated with smoke flavoring. We believe this requirement is sufficiently informative and does not in any regard misrepresent the meat and/or poultry food product to consumers.

This policy is consistent with current policy for labeling secondary products and is intended only to clarify the procedures already being implemented by the Division.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7239.4 Rev. 1	3-2-88

CHILD NUTRITION LABELING PROGRAM

I. PURPOSE

This directive describes procedures for the voluntary labeling of meat and poultry products under the CN labeling program administered by FNS in cooperation with FSIS.

II. CANCELLATION

FSIS Directive 7239.4, dated 3/9/87.

III. REASON FOR REISSUANCE

This directive has been revised to include the following:

A. Additional meat/meat alternate and bread/bread alternate food components,

B. Current MPI regulation cites which address the authorized label changes, and

C. Corrections to the CN logo.

IV. REFERENCES

MPI Regulations; Parts 317, 318, and 381,

7 CFR Parts 210, 220, 225 and 226, Child Nutrition Labeling Program, FNS;

FNS-245 - The Child Nutrition Labeling Program: An Overview; Child Nutrition Labeling for Nonmeat Products;

FNS-253 - Child Nutrition Labeling for Meat and Poultry Products, FNS;

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/SLD

Food Buying Guide for Child Nutrition Programs, Program Aid Number 1331, FNS;

Child Nutrition Labeling Program - Inspector's Guide Prepared by FNS for FSIS.

V. FORMS AND ABBREVIATIONS

The following will appear in their shortened form in this directive:

AMS	-	Agricultural Marketing Service
CN	-	Child Nutrition
FBG	-	Food Buying Guide for Child Nutrition Programs, Program Aid Number 1331, January 1984, FNS
FNS	-	Food Nutrition Service
MPIO	-	Meat and Poultry Inspection Operations, FSIS
NTSD	-	Nutrition and Technical Service Division, FNS
PPID	-	Processed Products Inspection Division, FSIS
SLD	-	Standards and Labeling Division, FSIS
USDA	-	United States Department of Agriculture

FSIS Form 8822-1 - Application For Approval of Labels, Marking or Device

VI. POLICY

FSIS is responsible for inspecting meat and poultry products that bear labeling identifying the product as contributing towards the child nutrition meal pattern requirements administered by the FNS.

A memorandum of understanding (MOU) has been entered into by FSIS, AMS and the National Marine Fisheries Service of U.S. Department of Commerce to provide the inspection of child nutrition labeled nonmeat and nonpoultry products.

VII. CHILD NUTRITION PROGRAM

A. The National School Lunch Program, School Breakfast Program, Child Care Food Program, and the Summer Food Service Program provide that a specific amount of food from each of four food components must be served. These four food components are: (1) Meat/Meat alternate (including meat, poultry, fish, eggs, cheese, +[nuts, seeds, nut or seed butters,]+ cooked dry beans or peas, vegetable protein products, cheese alternate products, and protein fortified +[macaroni),]+ (2) vegetable/fruit, (3) bread/bread alternate (such as enriched batter and/or breadings, taco shells, noodles, +[pizza crusts,]+ tortillas, and stuffing cracker crumbs), and (4) +[fluid]+ milk. To ensure that meals served in the child nutrition programs meet these meal pattern requirements, it is necessary to determine the contribution that individual foods make toward these requirements.

B. CN labeled meat and poultry products must:

1. Be evaluated to determine their contribution towards the meal pattern requirements using the **Food Buying Guide For Child Nutrition Programs** (Program Aid 1331, FNS.)

2. Be produced under federal inspection.

C. CN labels must contain the following information:

1. Product Name
2. Federal inspection legend containing the establishment number
3. Name and address of the manufacturer or distributor
4. Ingredients statement
5. CN label statement. This statement must be printed as an integral part of the product label and must include:

a. CN logo which is a distinct border around the CN statement.

b. A six-digit FNS assigned number in the upper right-hand corner of the CN label statement.

c. The statement of the product's contribution towards meal pattern requirements for the child nutrition programs.

d. A statement specifying that the use of the logo and CN statement is authorized by FNS.

e. The month and year that FNS approved (or is expected to approve within a 3-month range) the label in final form.

An example of a CN statement for a beef pattie containing a vegetable protein product is as follows:

CN

000000

This 3.00 oz serving of raw beef pattie provides when cooked 2.00 oz equivalent meat/meat alternate for Child

CN Nutrition Meal Pattern Requirements. (Use of this CN

logo and statement authorized by the Food and Nutrition Service, USDA 08-85*)

CN

+[*current month/year of final approval]+

VIII. SPECIAL CHARACTERISTICS OF CN LABELED PRODUCTS

A. CN labeled products must be evaluated on the basis of information contained in the FBG; therefore, it is imperative that information provided on FSIS Form 8822-1 is detailed and consistent with the food item in the FBG.

B. The product formula shown on FSIS Form 8822-1 must identify ingredients as follows:

1. Specify the maximum fat content of each meat used such as "ground beef (no more than 30 percent fat)".

2. If retail cuts, specify as shown in the FBG such as "beef chuck roast without bone".

3. Beef may not include "partially defatted chopped beef." If PDCB is used, it must be declared separately in the formula and on the label and is not creditable.

4. Ground beef is understood to be the standardized product provided for in section 319.15(a) of the meat inspection regulations.

5. The vegetable protein products must be identified by manufacturer, product name, and code. No substitutes are authorized unless shown on the approved FSIS Form 8822-1.

C. Processing procedures shown on FSIS Form 8822-1 must include all major steps in the preparations of the product including, but not limited to the following:

1. Raw and cooked weight of individual portions
2. Actual cooking yields (of bulk products)
3. Fill specifications
4. Internal temperature of the finished product

D. A CN labeled product is under a warranty as follows:

1. USDA has agreed that CN labeled products provide a warranty to the purchasing food service authority. If the CN labeled product is used in the child nutrition program according to directions, the institution will not have an audit claim filed against it for noncompliance of the CN labeled product with the meal pattern requirements.

2. If a State or Federal auditor finds that a CN labeled product does not actually meet meal pattern requirements claimed on the label, the auditor will report this finding to NTSD, who will prepare a report to MPIO for any action deemed necessary to correct the alleged noncompliance.

VI. RESPONSIBILITIES AND PROCEDURES

A. The FSIS Inspector in Charge must:

1. Assure that all labels bearing a CN statement have been approved by SLD, FSIS. Local CN label approvals are not authorized except for the label changes provided for in sections 317.5(b)+[(1), (2), (4), (5), (6), (8), (9), (10), (12), (13)]+ and 381.134 +[(b)(1), (2), (4), (5), (6), (8), (9), (10), (12), (13)]+ of the MPI regulations. However, portion size may not be changed. Whenever a product code number or a distributor is changed, send a copy of the new label to FNS.

2. Assure that quality control program for the product has been approved by PPID, FSIS, prior to production of the product.

3. Assure that the vegetable protein product, cheese alternate, or protein fortified macaroni used is identical to that shown on the approved label application, unless authorized in writing by FNS.

+[4. Assure that prepared meat/meat alternative components used as ingredients, e.g., pizza topping, bear prior CN label approval. Approved label must be attached to FSIS Form 8822.1.]+

5. Permit no substitution of any ingredient unless stated on FSIS Form 8822-1.

6. Assure that cooking yields are being maintained. The processor's cooking yield as stated on FSIS Form 8822-1 is a maximum value and may not be exceeded.

B. FOOD AND NUTRITION SERVICE, NTSD, WILL:

1. Evaluate product formulations and determine the accuracy of the CN statement on labels of meat and poultry products. The completed FSIS Form 8822-1, 6 copies, may be delivered to:

CN Label Reviewer - Room 602
Food and Nutrition Service, Nutrition and Technical Services Division
3101 Park Center Drive
Alexandria, VA 22302

2. Process the SLD, FSIS, copy of the FSIS Form 8822-1, authenticating and recording the date that action was taken.

3. Deliver, by either NSTD or an authorized establishment representative, the processed FSIS Form 8822-1 to SLD, FSIS, for further processing.

4. Provide food manufacturers with instructions for calculating the contribution that a meat or poultry product makes toward the meal pattern requirements, and for the design of the CN statement. The phone number for NSTD, FNS, is (703) 756-3556.

C. STANDARDS AND LABELING DIVISION, FSIS, WILL:

1. Maintain liaison with NTSD, FNS, to provide standards and labeling policy and interpretation of applicable meat and poultry products regulations.

2. Process FSIS Form 8822-1 and the accompanying CN label in accordance with section 317.4 of the meat inspection regulations.

3. Provide PPID, FSIS, with a copy of the approved CN label and FSIS Form 8822-1.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☒ AMENDMENTS
☐ OTHER

Child Nutrition Labeling Program	7239.4 Rev. 1 Amend. 1	7-7-88

I. PURPOSE

The purpose of this transmittal sheet is to transmit amendment 1 to FSIS Directive 7239.4 Rev. 1, dated 3-2-88.

II. CHANGE

The Child Nutrition (CN) Logo was depicted in the directive as containing broken vertical lines, whereas the Food and Nutrition Service requires solid lines on all sides. Many misinterpretations resulted from that logo in that the conclusion was that a new logo format was effective. Please note this is <u>not</u> a new CN logo.

III. FILING INSTRUCTIONS

Remove	Insert
Pages 3 & 4	Revised Pages 3 & 4

IV. CANCELLATIONS

After filing the revised pages in FSIS Directive 7239.4, Rev. 1, this transmittal sheet may be cancelled.

W. J. Horne

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/SLD

B. CN labeled meat and poultry products must:

1. Be evaluated to determine their contribution towards the meal pattern requirements using the Food Buying Guide For Child Nutrition Programs (Program Aid 1331, FNS.)

2. Be produced under federal inspection.

C. CN labels must contain the following information:

1. Product Name
2. Federal inspection legend containing the establishment number
3. Name and address of the manufacturer or distributor
4. Ingredients statement
5. CN label statement. This statement must be printed as an integral part of the product label and must include:

a. CN logo which is a distinct border around the CN statement.

b. A six-digit FNS assigned number in the upper right-hand corner of the CN label statement

c. The statement of the product's contribution towards meal pattern requirements for the child nutrition programs.

d. A statement specifying that the use of the logo and CN statement is authorized by FNS.

e. The month and year that FNS approved (or is expected to approve within a 3-month range) the label in final form.

An example of a CN statement for a beef pattie containing a vegetable protein product is as follows:

CN

000000

This 3.00 oz serving of raw beef pattie provides when cooked 2.00 oz equivalent meat/meat alternate for Child CN Nutrition Meal Pattern Requirements. (Use of this CN logo and statement authorized by the Food and Nutrition Service, USDA 08-85*)

CN

*current month/year of final approval

VIII. SPECIAL CHARACTERISTICS OF CN LABELED PRODUCTS

A. CN labeled products must be evaluated on the basis of information contained in the FBG; therefore, it is imperative that information provided on FSIS Form 8822-1 is detailed and consistent with the food item in the FBG.

B. The product formula shown on FSIS Form 8822-1 must identify ingredients as follows:

1. Specify the maximum fat content of each meat used such as "ground beef (no more than 30 percent fat)".

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3. Beef may not include "partially defatted chopped beef." If PDCB is used, it must be declared separately in the formula and on the label and is not creditable.

4. Ground beef is understood to be the standardized product provided for in section 319.15(a) of the meat inspection regulations.

5. The vegetable protein products must be identified by manufacturer, product name, and code. No substitutes are authorized unless shown on the approved FSIS Form 8822-1.

C. Processing procedures shown on FSIS Form 8822-1 must include all major steps in the preparations of the product including, but not limited to the following:

1. Raw and cooked weight of individual portions
2. Actual cooking yields (of bulk products)
3. Fill specifications
4. Internal temperature of the finished product

D. A CN labeled product is under a warranty as follows:

1. USDA has agreed that CN labeled products provide a warranty to the purchasing food service authority. If the CN labeled product is used in the child nutrition program according to directions, the institution will not have an audit claim filed against it for noncompliance of the CN labeled product with the meal pattern requirements.

2. If a State or Federal auditor finds that a CN labeled product does not actually meet meal pattern requirements claimed on the label, the auditor will report this finding to NTSD, who will prepare a report to MPIO for any action deemed necessary to correct the alleged noncompliance.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7310.4 REV 1	1-26-88

FOREIGN PARTICLE CONTAMINATION OF PRODUCTS

I. PURPOSE

The purpose of this directive is to provide instruction for inspection personnel to follow when an official establishment uses specifically approved devices to detect foreign particles (such as metal, plastic, rubber, glass) in meat and poultry products in which an incident is known to have occurred and a portion(s) of the product is suspected of being contaminated.

II. REASON FOR REISSUANCE

This directive is revised to include a sentence in paragraph VI.B. which denotes an acceptable measurement to be used in determining detection capability.

III. CANCELLATION

FSIS Directive 7310.4 dated 9/9/86.

IV. REFERENCES

MPI Manual, Section 8.31
MPI Regulations, Sections 308.5, 310.18, 318.2(d), 381.53, 381.78(a) and 381.91

V. POLICY

EXCEPTIONS: Exceptions to this directive are as follows:

A. Routine in-line screening devices voluntarily installed by establishment officials and product in which these screening devices detect one or several bits of particulate matter.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science ffices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/PPID

B. Product in which the inclusion of a missing component, such as a bolt or blade, can be shown to be still intact. In this case any reasonable establishment procedure, concurred by the IIC, may be used to isolate the component and show that no portion of the component is missing.

C. Product that is known to be contaminated and unsalvageable. In this case, the contaminated product is subject to condemnation.

FSIS has a responsibility for assuring that meat and poultry products produced under the Federal Meat Inspection Act and the Poultry Products Inspection Act are safe, wholesome and unadulterated. Frequently, when contamination occurs during processing, it is difficult to visually determine the precise amount of product affected. Establishments may elect to divert the entire amount of suspect product to non-human food channels, or submit a written proposal for re-examination of the product to assure that only sound, wholesome portions are accepted as inspected and passed.

VI. DETECTION EQUIPMENT GUIDELINES

A. All detection equipment must be acceptable to the Facilities, Equipment, and Sanitation Division (FESD), Equipment Branch, as set forth in Section 308.5 of the Meat Inspection Regulations and 381.53 of the Poultry Inspection Regulations.

B. Equipment used to re-examine product retained for suspicion of particulate contamination, except that mentioned in paragraph F. below, must be capable of detecting particles of 1/32" in the greatest dimension. Spheres of +[1/32" diameter]+ are acceptable for use in determining detection capability.

C. Prior to the detection operation, such equipment must be tested with seeded samples processed at the same rate of speed that will be used to process the suspect product.

D. The seeded samples must be of the same size, shape, and consistency as the retained product, seeded with appropriately sized contaminants of the same type material which the machine is intended to detect, and sufficiently identified to make retrieval easy.

E. At the discretion of the inspector, the same testing process should be use 2-4 times per hour during the actual re-examination of the suspected product to assure that the detection equipment is still operating properly.

F. X-RAY DETECTION EQUIPMENT

1. X-ray detection equipment must comply with special safety requirements as follows:

(a) The equipment must comply with Food and Drug Regulations 21 CFR 179.21. The applicable part of this regulation states that the radiation source must be X-ray tubes producing X-radiation from operation of the tube source at energy levels of 300 kilovolt peak or lower.

(b) The equipment shall bear a label identifying the source of radiation and maximum energy of radiation emitted by X-ray tube sources. This label or accompanying labeling material must also bear (1) adequate directions for installation and use, and (2) a statement that no food shall be exposed to the radiation sources listed above so as to receive an absorbed dose in excess of 1,000 rads.

2. Some State and local laws require plant employees and inspectors to wear radiation monitoring badges when working in the x-ray inspection area. Safety badges for inspection personnel are available from Area Offices that have identified plants in their purview that use fluroscopic equipment. Inspectors are required to wear the badges when working in the vicinity of X-ray detection equipment.

3. If a TV-type screen is used to monitor products for contamination, employees monitoring the screen must be relieved every 20 minutes or less to avoid eye/body fatigue, reducing the chance of missing visual detail.

VII. PROCEDURAL GUIDE FOR CONTAMINATED PRODUCT

A. When a product is suspected of being contaminated, it must be either rejected or re-examined to detect and remove any hard particles as large as 1/32" (0.8mm) in the largest dimension. At the inspector's discretion, seeded samples may be passed through the screening operation without the knowledge of the operator who monitors the process, thereby verifying the ability of both the equipment and the operator to detect the contamination.

B. If the operator/equipment monitoring the process is unable to identify the seeded sample, all product re-examined after the last identified seeded sample must be rerun or disposed of as non-human food. If the operators/equipment fail repeatedly, re-examination of contaminated product will cease until a more satisfactory method can be devised and approved, or the product diverted from human food use.

VIII. RESPONSIBILITIES

A. The Inspector-in-Charge will:

1. Retain all suspect contaminated product, and await information from the establishment as to what course of action they want to pursue.

2. Supervise the destruction of the entire lot or code if the establishment chooses, or supervise the destruction of that product which is still contaminated after the re-examination is completed.

3. If the establishment elects to re-examine, secure a written procedure from them. Such procedure must comply with Section VI and VII and, in addition, include the following information:

a. Description of the product (including amount).

b. Identity of the contaminant.

c. Description of how the contamination occurred.

d. Date that the contamination occurred.

e. Lots or codes involved.

f. Present status and location of product.

g. Detailed description of intended re-examination operation, to include sorting, reconditioning and/or disposition of the product.

h. Steps that will be taken to assure that the chances of future incidents of similar contaminated product will be minimal.

4. Review the proposal and forward it, with comments, to the Regional Director through supervisory channels. Copies should not be submitted if the establishments elects to destroy the entire lot or code of contaminated product.

5. Monitor all aspects of the re-examination including the adequacy and competency of establishment personnel conducting the operation.

B. The Circuit Supervisor/Area Supervisor will:

1. Review the establishment's proposed procedure.

2. Assure that the description of the incident is accurate and adequate.

3. Assure that the establishment has taken reasonable steps to prevent future incidents.

4. Forward the proposal, with comments, the the Regional Director.

C. The Regional Director will:

1. Review the recommendations submitted by the IIC, Circuit Supervisor and Area Supervisor and make the final decision regarding the acceptability of the proposal.

2. Coordinate with Processed Products Inspection Division (PPID) or Inspection Operations (MPIO) if unusual circumstances are involved or guidance is desired.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7355.1	2-4-88

USE OF SAMPLE SEALS FOR PROGRAM SAMPLES AND OTHER APPLICATIONS

I. PURPOSE

This directive establishes policy and procedures to be followed by Program personnel for the use of official sample seals for securing samples, test agar plates, and devices such as incubators, within or outside establishments. Security seals are intended to guard against tampering and to ensure the integrity of the sealed items or samples.

II. [RESERVED]

III. [RESERVED]

IV. REFERENCES

FSIS Directive 8150.1, dated 10/26/83.
FSIS Directive 8410.1, dated 3/1/83.
FSIS Directive 10,600.2, dated 8/14/84.
FSIS Directive 10,610.1, dated 3/10/86.
FSIS Directive 10,620.1, Amend. 3, dated 4/8/86.
FSIS Directive 10,625.1, dated 2/26/86.
MPI Bulletin 83-26, dated 5/10/83.
MPI Regulations, Sections 312.10 and 381.112.
MPI Manual, Part 23A.

V. FORMS

The following will appear in their abbreviated form in this directive:

FSIS Form 10,530-1	Monitoring Residue Program
FSIS Form 9770-2	Import Residue Program
FSIS Form 10,000-2	Laboratory Report
FSIS Form 10,600-1	Chemical Laboratory Analysis
FSIS Form 7355-1	Sample Seal (roll tape with die-cut seals)

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, R&E, TRA, ABB, AID, IFO

OPI: TS/Processed Products Inspection Division

VI. BACKGROUND

Until now, no unified system has existed to prevent tampering with samples submitted to laboratories for analysis or held for incubation in the establishment. (Agar plates (petri dishes) and incubators used in the STOP, CAST, and SIFT tests are included in this directive.) Regular, systematic use of sample seals is designed to protect against otherwise undetected opportunities for tampering with samples. The time period beginning when the sample leaves the inspector's control and ending when the sample is received at the laboratory or other location, or during incubation in the establishment, provides the greatest opportunity for tampering. Use of sample seals should minimize tampering risks and ensure that:

A. Sample integrity and identity are maintained; and

B. Subsequent analytical findings are reliably and accurately associated with the actual sample submitted.

VII. DESIGNATION OF LABORATORIES

Laboratory when used in this directive refers to:

A. The three Field Service Laboratories (Athens, GA, St. Louis, MO, and Alameda, CA);

B. The Beltsville National Laboratories, Beltsville, MD;

C. The FSIS Contract Laboratories; and

D. Accredited laboratories.

VIII. SEALING PROCEDURES

A. Seal the immediate package containing the sample (not the outside shipping container) so that the package cannot be opened unless the seal is broken.

B. If the surface of the immediate container is of a construction or condition that prevents a sample seal from adhering (waxed, frosted, or sweating surface), insert the immediate container in another container that a sample seal will adhere to.

C. For small size samples:

1. Place the sample in a plastic bag, twist top of bag, fold, and close with a rubber band. Place this bag into a second bag for added protection; and

2. Close the second bag in the same manner and affix a sample seal around the rubber band at the top of the bag so that the bag cannot be opened or the seal removed without evidence of damage.

D. For larger packages:

1. After wrapping and/or preparing the package to withstand handling, start at the top of the package and place an unbroken strip of suitable gummed tape completely around the package and continue to overlap the starting point of the tape at the top of the package. Where needed, protect package labeling in a suitable manner to ensure against defacing when the tape is removed;

2. Place a second unbroken strip of suitable gummed tape at a 90 degree angle to the first strip and wrap completely around the package. Overlap the second strip in the same place as the first; and

3. Apply the sample seal firmly and securely at the junction where the tape(s) meet and overlap. Press the entire surface of the seal to ensure proper adherence, making sure that the seal cannot be removed without becoming damaged.

E. For SIFT, CAST, and STOP tests or swab tests which require the use of agar plates (petri dishes) and/or incubators in the establishment:

1. Apply the sample seal to individual agar plates or stacks of plates incubating in the establishment very carefully to avoid tipping or dislodging the disk or swab; or

2. Avoid handling the test plates by using sample seal(s) to secure the incubator doors or other enclosed area, such as a desk drawer, where the plates are being incubated. Apply the security seal(s) firmly and securely at both junctions of the incubator door(s).

IX. RESPONSIBILITIES

A. Inspection Program Employee.

1. Signs, dates, and affixes a sample seal to each sample submitted to Program laboratories for analysis or the test agar plates (petri dishes) held for incubation in the establishment (or to incubator doors).

2. Completes the proper FSIS form (10,530-1, 9770-2, 10,000-2, or 10,600-1) to accompany a sample shipped to a Program laboratory.

3. Writes the serial number (printed in the upper right hand corner) of the form on the corresponding sample seal (on line marked Sample No._____), to avoid sample and paperwork mixup.

4. Uses the security seal as an in-plant or between-plant measure as necessary to maintain the security and integrity of both samples and products.

5. Takes appropriate action when the original sample seal(s) is reported or discovered to be broken, missing, or is suspected of having been tampered with.

6. Takes appropriate action after receiving returned lab forms with a condition code indicating a broken, missing or unsigned seal (see IX. B. 1. below).

7. Reports evidence of real or suspected tampering involving security seals to his/her supervisor.

8. Maintains security seals under control as required by FSIS.

B. Laboratory.

1. Records, when applicable, on Form 10,530-1, in block entitled "condition", on Form 9770-2 in block 29, on Form 10,000-2 in block 22, or on Form 10,600-1 in block 20, a condition code as follows:

(35) Sample seal broken
(36) Sample seal missing
(37) Sample seal unsigned

2. Analyzes the sample without retention or further consideration of the security seal.

C. Inspection Program Supervisor.

1. Reviews the use and control of sample seals during routine establishment visits.

2. Takes action to correct any problems identified.

D. Regional Offices and Import Field Offices.

Furnish sample seals as requested by Inspection Program Personnel.

Administrator

Attachments

1 FSIS Form 10,000-2
2 FSIS Form 10,600-1
3 FSIS Form 7355-1
4 FSIS Form 10,530-1
5 FSIS Form 9770-2

To Be Completed By Inspector

LAB ACC · DATE SAMPLES RECEIVED

USDA · FSIS · SCIENCE PROGRAM
LABORATORY REPORT
(Read instructions on reverse before completing)

SERIAL NO: 686407

1 PROJECT NAME OR CASE NO

2 RELATED SERIAL NOS

3 RETAIN TAG NO

4 REASON FOR SAMPLING (Check)
☐ 1 Inspector Initiated
☐ 2 Program Initiated

5 NAME AND ADDRESS OF PRODUCER, HERD OR FLOCK OWNER
State Code Zip Code

6 CODES
Region State Circuit

7 ESTABLISHMENT NO

8 PRODUCT SPECIES — Species Code

9 AGE (Approx.) Mo Yr.

10 SEX (Check) 1M 2F 3N

11A DATE COLLECTED Mo. Day Yr.

11B DATE MAILED Mo. Day Yr.

12 IMPORT PRODUCT — A COUNTRY NAME — CODE

B FOREIGN EST. NO.

C CUSTOMS ENTRY NO.

D MP FORM 410 NO.

13 REQUEST FOR (Check)
☐ Pathology ☐ Diagnostic Microbiology ☐ Food Microbiology ☐ Food Poisoning ☐ Species Identification — Residue Class Code — SPECIFIC RESIDUE
☐ 06 OTHER (Specify)

14 SPECIMEN (Check)
☐ 01 Fat ☐ 02 Liver ☐ 03 Muscle ☐ 04 Kidney ☐ 05 Inject Site

15 RELATED INFORMATION (Including Imports, Ante-Mortem, and Post-Mortem Remarks and Name of Recognized Laboratory)

16 NAME OF INSPECTOR (Type or Print)

17 TELEPHONE NUMBER (Include Area Code)

To Be Completed By Laboratory

18 FOR LABORATORY USE ONLY

19 DIAGNOSIS

20 FOR CHEMISTRY USE ONLY
☐ In Compliance ☐ In Violation

21 LAB CODE

22 CONDITION ON RECEIPT

23 ANALYSIS DATES
A STARTED (Mo. Day, Yr.) B COMPLETED (Mo. Day, Yr.)

24 NO. 1 / 25 NO. 2 / 26 SIGNATURE OF ANALYST(S)

27 ANAL CODE

28 INITIALS

29 REVIEWED (Initials)

FSIS FORM 10,000-2 (7/88) REPLACES FSIS FORM 6000-1 (8/81), WHICH MAY BE USED UNTIL EXHAUSTED.

Part 1 - LABORATORY (send to Regional Office)
(Inspector: insert name and address on reverse of part 1, or include in self-addressed envelope)

USDA FSIS

CHEMICAL LABORATORY ANALYSIS

1. STATE CODE | CIRCUIT CODE | 2. ESTABLISHMENT NO. | 3. RETAIN TAG NO

294968

4. FEDERAL PROGRAM CHARGEABLE (Check)
MEAT 1 ☐ POULTRY 2 ☐ VOLUNTARY INSPECTION (Identify service) 3 ☐ OTHER (Specify) 4 ☐

5. DATE COLLECTED MONTH | DAY | YEAR

6. PRODUCT CODE | 7. LABORATORY NAME | LAB CODE

8. TYPE OF SAMPLE (Check) SINGLE 1 ☐ COMPOSITE 2 ☐ IF COMPOSITE - HOW MANY?

9. CHECK IF APPLICABLE RETAIL SAMPLE 4 ☐ SUPERVISORY SAMPLE 2 ☐

10. IMPORT PRODUCT

a. COUNTRY NAME | CODE | b. FOREIGN EST. NO. | c. CUSTOMS ENTRY NO. | d. FSIS USE

11. INSPECTOR OR COLLECTOR (Type or print) | INITIALS

12. ANALYSES REQUESTED AND FINDINGS

☐ TOT. PROTEIN 01 %	☐ MEAT PROTEIN 02 %	☐ TOTAL WATER 03 %	☐ ADDED WATER 04 %	☐ + ADD. SUBS. 05 %	☐ - ADD. SUBS. 06 %	☐ SALT 07 %
☐ TOTAL FAT 08 %	☐ MAX. INT. TEMP. 09 °F.	☐ SODIUM NITRITE 10 P.P.M.	☐ SODIUM NITRATE 11 P.P.M.	☐ PHOSPHATE 12 %	☐ N.F.D. MILK 13 %	☐ CALCIUM REDUCED D.S.M. 14 %
☐ CEREAL 15 %	☐ SOY FLOUR 16 %	☐ SOY PROTEIN CONCENTRATE 17 %	☐ I.S.P. 18 %	☐ C.S.S. 19 %	☐ [illegible] 20 %	☐

13. NAME OF ARTICLE AS LABELED AND INGREDIENTS

14. FOR ALL CHEMISTRY SAMPLES (Check)
☐ IN COMPLIANCE
☐ ACTION BY INSPECTOR (Inspector complete items 31 thru 36 on reverse)

15. ESTIMATED PERCENT IN FINISHED PRODUCT (Inspector's calculations)

a. N.F.D. MILK %	b. I.S.P. %	c. SOY PROTEIN CONCENTRATE %	d. SOY FLOUR %	e. H.V.P. %	f. M.S.G. %	g. GELATIN %

COMPLETE FOR ACCREDITED LABORATORY EVALUATION ONLY

16. SAMPLE NO. → | 17. CHECK ANALYSIS REQUIRED → | a. TOT. PROTEIN % | b. TOT. WATER % | c. TOT. FAT % | d. TOT. SALT %

18. FOR LABORATORY USE ONLY (Results, additional laboratory findings such as description of sample(s), reserve sample(s))

19. DATE REC'D.	20. CONDITION ON RECEIPT	21. ANALYSIS a. STARTED	b. COMPLETED	c. HRS.	22. ANALYST(S) CODE	23. SIGNATURE OF CHEMIST IN CHARGE

FSIS FORM 10,600-1 (10/96)

COPY 1: LABORATORY - Send to Inspector.

294968

TYPE OF PRODUCT | DATE SUBMITTED

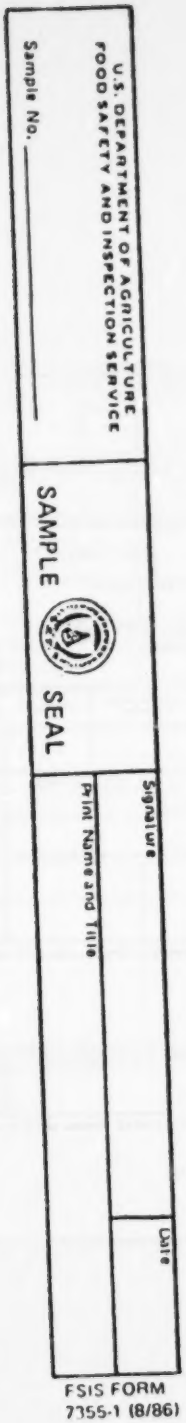
BRIEF NATURE OF REQUEST

RETAIN TAG NUMBER | INSPECTOR | ESTABLISHMENT NO.

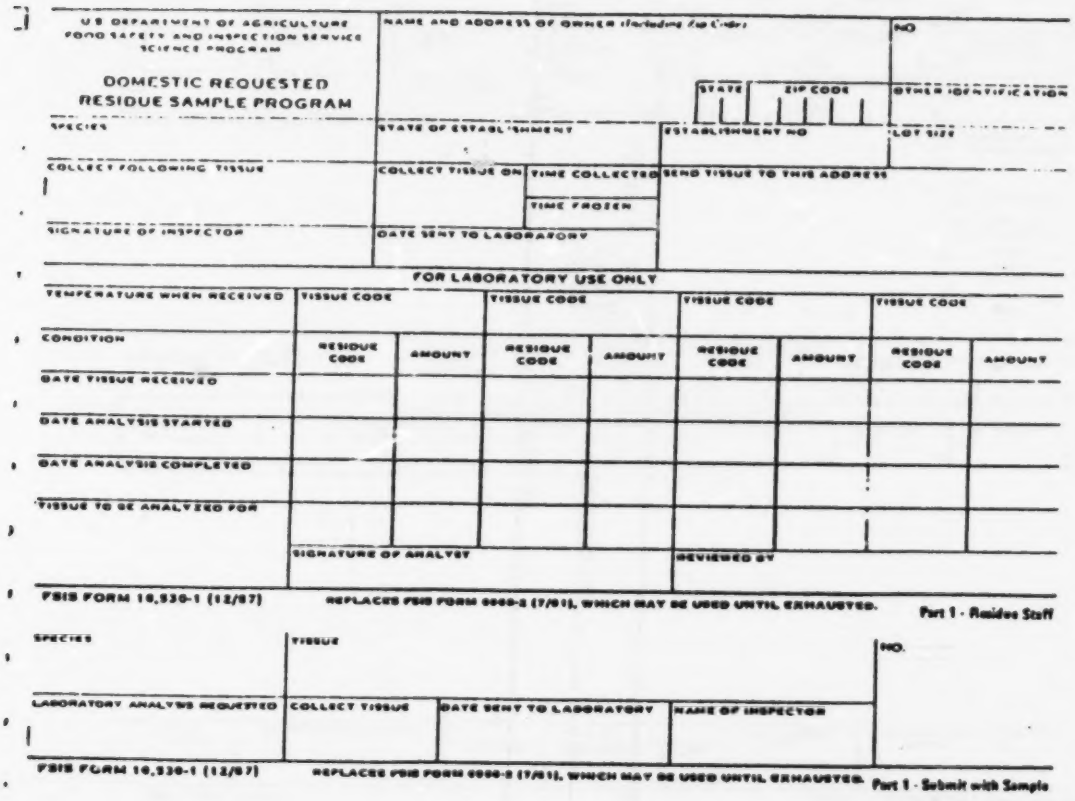
FSIS FORM 10,600-1 (10/96)

REPLACES FSIS FORM 6200-1 (4/85), WHICH MAY BE USED UNTIL EXHAUSTED.

TEAR STRIP 1: INSPECTOR ATTACH TO SAMPLE
(Inspector: Insert name & address on reverse of copy 1, or include self-addressed envelope in plastic bag)



FSIS FORM
7355-1 (8/86)



U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
SCIENCE PROGRAM

DOMESTIC REQUESTED RESIDUE SAMPLE PROGRAM

NAME AND ADDRESS OF OWNER (Including Zip Code)

NO.

STATE | ZIP CODE | OTHER IDENTIFICATION

SPECIES | STATE OF ESTABLISHMENT | ESTABLISHMENT NO. | LOT SIZE

COLLECT FOLLOWING TISSUE | COLLECT TISSUE ON | TIME COLLECTED | SEND TISSUE TO THIS ADDRESS

TIME FROZEN

SIGNATURE OF INSPECTOR | DATE SENT TO LABORATORY

FOR LABORATORY USE ONLY

TEMPERATURE WHEN RECEIVED	TISSUE CODE		TISSUE CODE		TISSUE CODE		TISSUE CODE	
CONDITION	RESIDUE CODE	AMOUNT	RESIDUE CODE	AMOUNT	RESIDUE CODE	AMOUNT	RESIDUE CODE	AMOUNT
DATE TISSUE RECEIVED								
DATE ANALYSIS STARTED								
DATE ANALYSIS COMPLETED								
TISSUE TO BE ANALYZED FOR								

SIGNATURE OF ANALYST | REVIEWED BY

FSIS FORM 10,330-1 (12/87) REPLACES FSIS FORM 6000-2 (7/81), WHICH MAY BE USED UNTIL EXHAUSTED. Part 1 - Residue Staff

SPECIES | TISSUE | NO.

LABORATORY ANALYSIS REQUESTED | COLLECT TISSUE | DATE SENT TO LABORATORY | NAME OF INSPECTOR

FSIS FORM 10,330-1 (12/87) REPLACES FSIS FORM 6000-2 (7/81), WHICH MAY BE USED UNTIL EXHAUSTED. Part 1 - Submit with Sample

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE

IMPORT RESIDUE PROGRAM

1. IMPORT FIELD OFFICE LOCATION	2. IFO NO.	3. FSIS 9540-1 NO.	4. LOT	SERIAL NO.

5. NAME OF PRODUCT	13. SAMPLING PROGRAM (Mark ✓ one) ☐N Normal ☐I Increased ☐S Special ☐F HOLD (for this residue)	14. SPLIT SAMPLE ☐Yes ☐No (If yes) ACCREDITED LAB NAME:	18. I-/DOMESTIC ESTABLISHMENT NO.
6. PRODUCT CODE			19. WAREHOUSE LOT NO.
7. HEALTH CERTIFICATE NO.			20. DATE SAMPLED / 21. DATE MAILED
8. SHIPPING MARKS			22. INSPECTOR'S NAME (Print)
9. NO. OF F SAMPLES ASSIGNED THIS LOT		15. SPLIT SAMPLE NO.	23. BADGE NO.
10. COUNTRY OF ORIGIN / 11. CODE	16. ANALYSIS REQUESTED		24. SIGNATURE OF INSPECTOR
12. FOREIGN ESTABLISHMENT NO.	17. COMMENTS		

FOR LAB USE ONLY

25. DATE RECEIVED	26. SAMPLE RESULT CODE	27. QUANTITATIVE RESULTS					
		TISSUE CODE:			TISSUE CODE:		
		Analyte	Residue Code	Amount	Analyte	Residue Code	Amount
28. DATE ANALYSIS STARTED	29. CONDITION CODE						
30. DATE OF OFFICIAL RESULTS	31. LAB CODE						
32. SIGNATURE OF OFFICIAL-IN-CHARGE							

FSIS FORM 9770-2 (2/87) REPLACES FSIS FORM 4689-4 (7/82), WHICH IS OBSOLETE. ALL PREVIOUS EDITIONS ARE OBSOLETE.

LABORATORY FILE COPY

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7520.2 | 5-12-88

PROCEDURES FOR CONDITION OF CANNED PRODUCT CONTAINER EXAMINATION

I. PURPOSE

This directive describes the procedures for examining the condition of canned product containers. FSIS inspectors conduct routine examinations to determine the integrity of canned product containers, special examinations to investigate suspect lots of canned product containers, and additional examinations to evaluate sorted/reconditioned lots of canned product containers. This directive does not apply to examinations of imported canned product containers.

II. [RESERVED]

III. [RESERVED]

IV. REFERENCES

MPI Regulations, sections 318.309 and 381.309.

V. INDEX

A. Definitions

B. Stationary Lot Sampling--Procedures and Disposition

1. Scope
2. Sampling plans and defects
   a. Normal sampling plan
   b. Tightened sampling plan
   c. Defect classifications
3. Materials needed
4. Basis for selection of samples
5. Random sampling
6. Preliminary scanning of shipping containers

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/PPID

7. Sample selection
8. Examining, classifying and recording defects
9. Decisions on acceptance
10. Defective sample unit disposition
11. Disposition of rejected lots

C. Condition of Container Score Sheet, FSIS Form 7520-1 (Attachment 1)

D. Examples of Condition of Container Examination (Attachment 2)

E. Random Numbers (Attachment 3)

F. Random Numbers Worksheet for Example 1.0 (Attachment 4)

G. Random Numbers Worksheet for Example 2.0 (Attachment 5)

VI. DEFINITIONS

A. General

Acceptance Number (Ac). The maximum number of defects allowed in a sample to accept a lot based on a sampling plan.

Canned Product. A food product with a water activity above 0.85 which receives a thermal process either before or after being packed in a hermetically sealed container.

Defect classifications.

1. **Critical defect** (I). An abnormality which indicates that the container is not hermetically sealed (such as, holes, fractures, leakage) or shows evidence that there may be spoilage of the container's contents.

2. **Major defect** (II). An abnormality that may affect container integrity.

Destination Examination. An examination made at any location other than at the producing establishment.

Hermetically Sealed. Air-tight containers which protect the contents against the entry of microorganisms during and after thermal processing.

Lot. A collection of hermetically sealed containers of the same size, type, and style. Lots should be distinguishable by product name, code, formulation and date of production.

Origin examination. An examination made prior to shipment from the producing establishment.

Random sampling. A process of selection whereby each container has an equal chance of being chosen.

Related defects. Defects on a single container that may have resulted from a single cause.

Rejection number (Re). The number of defects in a sample that will cause the lot to be rejected as specified in a sampling plan.

Sample. A collection of sample units.

Sample size. The number of sample units which are to be included in the sample.

Sample unit. An individual hermetically sealed container.

Shelf stable. The condition achieved by the application of heat, sufficient alone or in combination with other ingredients and/or treatments, to render the product free of microorganisms capable of growing in the product at nonrefrigerated conditions (over 50°F. or 10°C.) at which the product is intended to be held during distribution and storage.

Stationary lot sampling. The process of randomly selecting sample units from a lot that has been warehoused or prepared for shipment.

Unrelated defects. Defects on a single container that may have resulted from separate causes.

B. External Container Defects

Buckle or Peak. A distortion of the container where the ends exhibit one or more permanent ridges extending into the countersink.

Corrosion. A chemical deterioration of the container. Rusting is one form of corrosion.

Cut Seam. A cut through a layer of the double seam.

Cutover or Sharp Seam. A sharp lip formed at the top inside edge of the double seam where no fracture of the seam is evident.

Deadhead, Spinner, Skidder or Skip Seam. A double seam which has not been completed.

Droop. A smooth crescent-like projection at the bottom of the bottom seam.

Incomplete Seam. A portion of the double seam where the body and cover hooks are not engaged.

Knocked Down Cover. A cover hook is not engaged with the body hook resulting in the cover curl extending below the double seam.

Knocked Down Flange. The flange is bent resulting in no engagement of the body and cover hooks.

Leakage. Loss of hermetic seal.

Paneled. The container side(s) is drawn excessively inward.

Swollen. A bulging of the container which may be due to the formation of gas.

1. **Burst.** A rupture of the container caused by excessive internal pressure.

2. **Flipper.** A slight distention of one end of the container where outside pressure will return the end to normal position but will cause the other end to "flip" out.

3. **Hard Swell.** A severe and permanent outward bulge on the container.

4. **Loose Tin.** A metal can which does not appear swollen, but slight pressure reveals a looseness.

5. **Soft Swell.** A slight distention of the container which will yield when pressure is applied, but cannot be forced back to a normal condition.

6. **Springer.** A slight distention of the container end where pressure will return the end to a normal position until the pressure is released.

Note: Overfilled, overstuffed or short vacuum may result in swelling and must be confirmed by laboratory analysis.

Vee or Spur. A projection at the bottom of the double seam which is shaped like the letter V.

VII. CONDITION OF CONTAINER EXAMINATION—STATIONARY LOT SAMPLING

A. Scope

1. The following procedures are to be used when assessing the condition of containers in stationary lots (lots warehoused and/or ready for shipment) of shelf stable canned foods. The procedures apply to those canned foods covered by Subpart G of the meat inspection regulations and Subpart X of the poultry products inspection regulations.

2. Routine examinations should be conducted at least once per month. Frequencies may vary according to current FSIS policy. Such examinations may be initiated by the inspector or as directed when there is reason to suspect the integrity of the container.

B. Sampling Plans and Defects

1. Table 1 of FSIS Form 7520-1 (Score Sheet), shows the number of sample units to select based on lot size. The table provides acceptance (Ac) and rejection (Re) criteria based on the number, class, and type of defects. Two-step sampling plans are used for routine sampling. Single sampling plans are used for tightened sampling.

2. The two-step sampling plan provides for acceptance or rejection based on results of the 1st step. When the results of the 1st step fall between acceptance and rejection, proceed to examination of 2nd step sample units. If both steps are needed, acceptance/rejection is based on the total sample results.

3. Defect classifications are listed in the Score Sheet. For container types not included in the Score Sheet, (such as, semirigid), use section B-1 of the Score Sheet and criteria for heat seals as provided in the establishment's Partial Quality Control (PQC) program or Total Quality Control (TQC) system.

C. Materials Needed

1. A copy of this FSIS Directive.

2. FSIS Form Nos. 7520-1 and 7520-2.

3. Acceptable equipment and facilities.

D. Basis for selection of samples

1. Lot and Sample Identification. Complete Section A of the Score Sheet for lot identification.

2. Sample Size. How to determine the number of containers needed:

a. Select the appropriate sampling plan from Table 1 of the Score Sheet. The sampling plan is based on the size of the lot.

b. The normal sampling plan will be used for routine examinations or when there is a reason to suspect the integrity of the container.

c. The tightened sampling plan will be used for lots which failed previous condition of container examinations or when directed. (Do not examine a previously failed lot unless evidence is presented that the lot has been reconditioned or sorted and the sorted defective containers are made available for examination.)

E. Random Sampling

Selection of random numbers. The random numbers table provided in Attachment 3 may be used to select your random numbers. Use the examples outlined in Attachment 2 to determine the number of random numbers you will need.

F. Preliminary Scanning of Shipping Containers

Before drawing the sample, conduct an overview of the entire lot to determine if there are any abnormal conditions (such as, wet cases, ruptured containers, corroded or leaking containers, damaged cases or containers). If such conditions are noted, the lot may be rejected without sampling. (Note, when there is obvious forklift or transportation damage, the inspector may permit removal of the damaged containers without rejecting the lot provided the damage is not a prevailing condition throughout the lot. This would also apply to lots not selected for examination where similar conditions prevail.)

G. Sample Selection

1. For double sampling, select the random numbers, and identify and mark the shipping cases for both steps. Be sure to distinguish between 1st and 2nd step (for example, an "X" for first step and "XX" for 2nd step). The establishment removes the marked cases. At this time, removal of the 2nd step sample portion from the lot is at the establishment's option.

2. For single sampling (tightened sampling), select the random numbers, and identify and mark the shipping cases.

H. Examining, Classifying and Recording Defects

1. Perform sample unit examinations after the 10 day incubation period has elapsed. This will allow for potential microbial action.

2. Examine each sample unit for the defects shown on the Score Sheet. Defects not listed on the Score Sheet, should be classified in blocks 104 or 208, whichever is applicable. Record all results on a Score Sheet. Label removal is only required when there is evidence of stains or damage or when container overwraps obscure visual examination.

3. Product containers with defects that are not part of the sample must be removed and handled per paragraphs I.3. and J.

4. When two or more defects are found on the same sample unit and indicate the same cause, the defects are considered related and scored once. For example, if two locations are corroded, score once. If more than one related defect is found and one is critical and the other is major, score once as critical. If the defects on the sample unit indicate different causes, then the defects are considered unrelated and scored as separate defects. For example, if a can is dented and has a sharp seam, two defects would be scored.

5. If you notice a recurrence of scorable or unscoreable defects, you may note this in the remarks section of the Score Sheet as a reminder to conduct further investigations. (Note: An unscoreable defect is a defect often referred to as a minor defect. A minor or unscoreable defect has no adverse effect on container integrity.)

I. Decision on Acceptance

1. Normal sampling. After the 1st step is completed, the lot may be accepted or rejected or 2nd step sampling may be completed. When 2nd step is completed, the results are combined with 1st step results and a decision is made to accept or reject the lot.

2. Tightened sampling. The lot is either accepted or rejected based on sample results.

3. If swollen containers (Defect #101) are found and the container(s) exhibits no obvious mechanical defect, the lot must be retained pending laboratory analysis. Notify your supervisor and the Microbiologist-In-Charge at the designated FSIS laboratory. For establishments under a TQC system or a PQC program for finished product inspection in accordance with §§318.309 and/or 381.309, follow the procedures outlined in the TQC system or the PQC program.

J. Defective Sample Unit Disposition

1. Containers scored critical with obvious mechanical defects must be destroyed.

2. Whenever any major defects are found in the sample, the establishment may decide on the disposition of these containers.

3. For establishments under a TQC system or a PQC program, defective sample units will be disposed of as outlined in the system or program.

K. Disposition of Rejected Lots

The establishment must provide a written proposal to the inspector before lot disposition. The proposal must include disposition of all defective containers in accordance with § 318.309 (d)(2)(ii) and/or § 381.309 (d)(2)(ii) of the regulations. The inspector must compare the establishment's proposal with any FSIS instructions given for that lot.

Deputy Administrator
Meat and Poultry Inspection Operations

Attachments

1-Condition of Container Score Sheet, FSIS Form 7520-1

2-Examples of Condition of Container Examination

3-Random Numbers

4-Random Numbers Worksheet for Example 1.0

5-Random Numbers Worksheet for Example 2.0

CONDITION OF CONTAINER SCORE SHEET

A. LOT AND SAMPLE IDENTIFICATION

PRODUCT		CONTAINER CODE(S) / LOT NO	TYPE OF CONTAINER (Glass, Metal, etc.)
SIZE OF CONTAINER (Net wt. and dimensions)	NO OF CONTAINERS IN LOT	EST NO WHERE INSPECTED	PRODUCED AT EST NO
COMPANY NAME AND ADDRESS WHERE INSPECTED		TYPE OF INSPECTION ☐ Original ☐ Reinspection	SAMPLING PLAN ☐ Normal ☐ Tightened
		NO OF SAMPLES: 1st Step / 2nd Step / TOTAL	

B. DEFECT DESCRIPTIONS (I) = Critical (II) = Major

B.1 - *Affecting All Container Types*

Defect No	Crit / Maj	TYPE OF DEFECT	TALLY 1st Step	TALLY 2nd Step	Defect No	Crit / Maj	TYPE OF DEFECT	TALLY 1st Step	TALLY 2nd Step
101	(I)	Swollen – Burst, Hard Swell, Soft Swell, Flipper or Springer Loose Tin			105	(I)	Broken Score Line or Tearstrip		
102	(I)	Corrosion *(If Through Container Wall)*			106	(I)	Dents *(Fractures or Damage Impedes Exam)*		
201	(II)	Corrosion *(Severely Pitted, Not Through Container Wall)*			205	(II)	Dents or Panels *(Causing Body Creases or Affecting Seal or Score with No Cracks)*		
103	(I)	Buckle or Peak Into Seam *(Evidence of Leakage)*			107	(I)	Evidence of Leakage *(If No Other Criteria Apply)*		
202	(II)	Buckle or Peak Into Seam *(No Evidence of Leakage)*			108	(I)	Other Critical Defects--Explain *(If No Blocks Apply)*		
104	(I)	Cut Through, Fractures, Holes, or, Punctures *(Not on Seam or Seal)*			204	(II)	Other Major Defects--Explain *(If No Blocks Apply)*		

B.2--(Cont) with Double Seams

109	(I)	Incomplete Seam *(False, Knocked Flange / Cover)*			207	(II)	Vee, Spur, or Droop *(More Than 1 / 3 Seam Height, No Leakage)*		
110	(I)	Cut Seam or Abrasion Through One Layer of Seam			112	(I)	Deadhead, Skidder, Spinner, or Skip Seam		
205	(II)	Cutover / Sharp Seam *(No Evidence of Leakage)*			113	(I)	Side Seam Cracked or Opened Including Voids		
206	(II)	Cut Seam or Abrasion, Not Through One Layer of Seam			208	(II)	Mislocked Side Seam *(No Evidence of Leakage)*		
111	(I)	Vee, Spur, or Droop *(Evidence of Leakage)*							

B.3--Glass Jars

114	(I)	Loss of Vacuum			209	(II)	Damaged Seal Area (Cap) *(No Evidence of Leakage)*		
115	(I)	Missing, Loose or Cocked Cap			210	(II)	Glass Imperfections *(No Evidence of Leakage)*		
116	(I)	Broken, Fractured, Cracked Jar			211	(II)	Glass Bubble Exceeding 1 / 8 inch Diameter		
117	(I)	Damaged Seal Area (Cap) *(Evidence of Leakage)*			212	(II)	Product Under Cap *(Not Affecting Seal)*		

B.4--Flexible Containers with Heat Seals

118	(I)	Less Than 1 / 16 inch Continuous Defect-Free Seal			214	(II)	Severely Distorted		
213	(II)	Delamination in the Product Area Greater Than 1 / 16 inch							

REMARKS

DEFECTS	CRITICAL	CRITICAL AND MAJOR
1st Step		
2nd Step		
TOTAL DEFECTS		

HELD FOR LABORATORY ANALYSIS ☐ Yes ☐ No

LOT ☐ Accepted ☐ Rejected

SIGNATURE OF INSPECTOR

DATE

SAMPLE COPY

FSIS FORM 7520-1 (2/88) REPLACES FSIS FORM 8110-1 (8), WHICH MAY BE USED UNTIL EXHAUSTED USDA-FSIS

FSIS FORM 7520-1 *(REVERSE)*

C. SAMPLING PLANS

Table 1

LOT SIZE (CONTAINERS)	SAMPLE SIZE (CONTAINERS)		CRITICAL DEFECTS (I)		TOTAL CRITICALS AND MAJORS			
					ORIGIN		DESTINATION	
NORMAL PLAN	2-STEP SAMPLING		AC	RE	AC	RE	AC	RE
6,000 or Less	1st Step	120	0	1	2	5	2	6
	2nd Step	60						
	Total	180	0	1	4	5	5	6
6,001-12,000	1st Step	168	0	2	1	5	2	7
	2nd Step	180						
	Total	348	1	2	7	8	9	10
12,001-36,000	1st Step	228	0	3	3	7	3	9
	2nd Step	288						
	Total	516	2	3	6	10	12	13
36,001 or Larger	1st Step	456	0	4	5	10	8	13
	2nd Step	408						
	Total	864	3	4	14	15	19	20
TIGHTENED	SINGLE SAMPLING							
6,000 or Less		300	0	3	5	6	6	7
6,001-12,000		475	1	2	8	9	11	12
12,001-36,000		630	1	3	10	11	14	15
36,001 or Larger		800	1	4	12	13	17	18

Table 2

CONTAINERS IN A CASE	MAXIMUM SAMPLE UNITS PER CASE
5 or Less	All
6-12	6
13-60	12
61-250	16
251 or More	24

SAMPLE COPY

DEFECT CLASSIFICATIONS:

(a) **Critical defect (I).** An abnormality which indicates that the container is not hermetically sealed *(e.g., holes, fractures, leakage)* or shows evidence that there may be spoilage of the container's contents.

(b) **Major defect (II).** An abnormality that may affect container integrity.

NOTE: IF SWOLLEN CONTAINERS *(Defect No. 101)* ARE FOUND AND THE CONTAINER(S) EXHIBITS NO OBVIOUS MECHANICAL DEFECT, THE LOT MUST BE HELD PENDING LABORATORY ANALYSIS. NOTIFY YOUR SUPERVISOR AND THE MICROBIOLOGIST-IN-CHARGE AT THE DESIGNATED FSIS LABORATORY. For establishments under a Total Quality Control (TQC) system or a Partial Quality Control (PQC) program per 9 CFR 318.309, follow those procedures.

Upon completion of the examination, file the original scoresheet and random numbers worksheet. Retain originals for 3 years.

EXAMPLES OF CONDITION-OF-CONTAINER EXAMINATION

Example 1.0 A lot of 28,800 metal cans is to be examined under the normal sampling plan. The lot is palletized and cased - 2400 cases (12 cans per case) arranged on 50 pallets each holding 48 cases. The sample size is 228 sample units (cans) for the first step. (See Section C of the Score Sheet for sampling plans.)

You have decided to take 1/2 of the maximum number of cans from a case permitted in Table 2 of the Score Sheet; that is, 3 cans from each case. The selection of 228 cans for the first step proceeds as follows:

1.1 How to determine the total number of cases to examine:

$$\frac{228}{3} \quad \frac{\text{(sample units required)}}{\text{(No. of cans/cases to examine)}} \quad = \quad 76 \text{ (cases to examine)}$$

(228 ÷ 3 = 76)

If the number of cases to be examined is greater than the number of pallets, a case(s) will be drawn from each pallet.

1.2 How to determine the total number of cases per pallet to be examined:

$$\frac{76}{50} \quad \frac{\text{(cases to examine)}}{\text{(No. of pallets)}} \quad = \quad \text{1 case per pallet plus 26 cases (1 more from each of 26 pallets)}$$

1.3 Designate numbers for each pallet from 1 through 50 on a Random Numbers Worksheet (See Attachment 4). Remember there are 48 cases on each pallet.

1.4 Draw 1 usable number (1 through 48) from the random number table. This indicates the case to be drawn from the first pallet. Repeat the process for each of the remaining 49 pallets.

1.5 Draw 26 usable numbers (1 through 50) from the random numbers table. These 26 numbers indicate the 26 additional pallets from which to select the additional cases.

1.6 Repeat the case selection procedure in 1.4, drawing 26 usable numbers to identify the 26 additional cases needed. (One case from each of the 26 pallets selected in 1.5.) Select another random number if a case number was previously selected for that pallet.

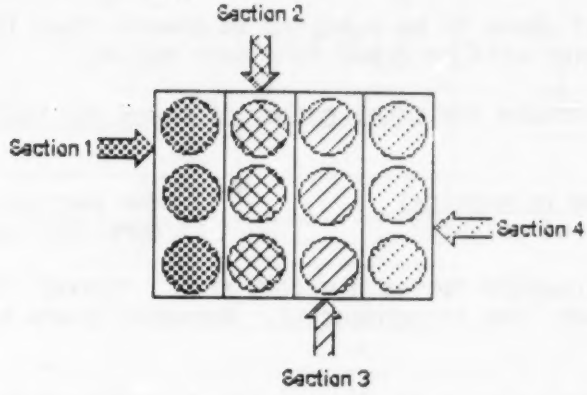
1.7 For 2nd step sampling, 288 cans are needed. Two cases from 46 pallets and 1 case from 4 pallets would be selected. Thus, select 4 random numbers from 1 through 50 to determine the four pallets from which only one case will be drawn. Draw two usable numbers (1 through 48) for

each pallet requiring selection of two cases and one useable number (1 through 48) for each pallet requiring the selection of one case. For individual pallets, if any numbers from first step are duplicated, select additional numbers so that no case is sampled more than once. (See Attachment 4 for a completed worksheet of this example.)

1.8 Assign cases on each pallet consecutive numbers from 1 through 48 using a predetermined pattern (such as, top to bottom, left to right).

1.9 Group the cans in each case into 4 adjacent sections of 3 cans. For example, the cans could be sectioned as follows:

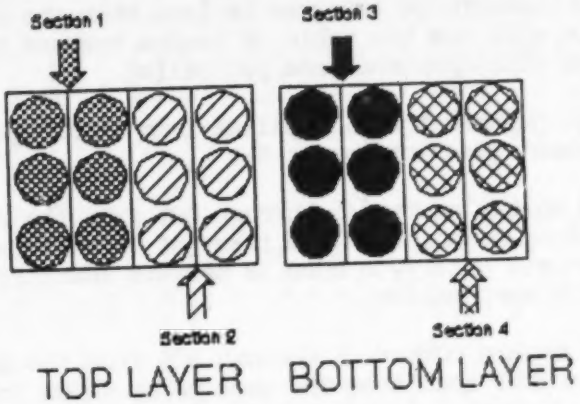
Figure



When looking at the cans in the first case to be examined, you may start with section 1. The second case to be selected may have cans examined from section 4. The third case sample units may be from section 2 and the fourth case sample units from section 3. This cycle should be repeated until all sampling is completed.

Consider the situation where you might have cases containing 24 cans each. You decide to look at 6 cans from each of a predetermined number of cases. The sectioning of the cans could be as follows:

Figure



The cycle could be as follows:

Case 1	Section 2
Case 2	Section 3
Case 3	Section 4
Case 4	Section 1
Case 5	Section 2
Case 6	Section 3
Case 7	Section 4
Case 8	Section 1
Case 9	Section 2
etc.	etc.

Example 2.0 A lot of 28,800 metal cans is to be examined under the normal sampling plan. The lot is palletized and cased - 2,400 cases (12 cans per case) arranged on 80 pallets, each holding 30 cases. The sample size is 228 sample units (cans) for the first step.

You have decided to take the maximum number of cans from a case as specified in Table 2 of the Score Sheet; that is, 6 cans from each case. The selection of 228 cans for the first step proceeds as follows:

2.1 $\frac{228}{6}$ $\frac{\text{(sample units required)}}{\text{(No. of cans/cases to examine)}}$ = 38 (cases to examine)
(228 ÷ 6 = 38)

The number of cases to be examined is less than the number of pallets. Therefore, you will use the table of random numbers to select the pallets from which you will draw one case per pallet.

2.2 Designate numbers for each pallet from 1 through 80 on a Random Numbers Worksheet (See Attachment 5).

2.3 Draw one usable number (1 through 80) from the random numbers table. This number indicates the first of 38 pallets to be selected. Repeat the process until you have 38 pallets identified. (Remember there are 30 cases on each pallet.)

2.4 Draw one usable number (1 through 30) from the random numbers table. This number indicates the case to be drawn from the first pallet selected in 2.3 above. Repeat the process for each of the remaining 37 pallets.

2.5 For 2nd step sampling, repeat 2.1 through 2.4 to draw a set of random numbers based on 288 cans. For individual pallets, if any numbers from 1st step sampling are duplicated, select additional numbers so that no case is sampled more than once. (See Attachment 5 for a completed worksheet of this example.)

2.6 Follow 1.8 for case numbering and 1.9 for case sectioning.

Example 3: This lot contains 50 pallets (48 cases each—6 cans per case). Since 19 pallets were distributed, only 31 pallets are available for sampling. The remaining portion of the lot consists of 8,928 cans. Follow procedures outlined above in Examples 1.0 and 2.0. Results may require action regarding the 19 pallets not available for examination. Make a note in the remarks section of the Score Sheet that not all cans from the lot were available.

Random Numbers

3 3 9 [illegible] 7 0	2 9 0 3 1 4	1 4 3 6 8 8	4 4 4 5 2 2	9 0 0 0 1 2	7 6 0 1 8 0
6 5 1 0 4 4	0 3 4 6 4 6	3 4 6 4 8 0	0 2 1 9 3 8	3 4 0 2 2 9	0 4 3 4 7 0
6 5 9 3 5 4	0 8 3 8 9 6	9 9 2 2 8 1	2 6 7 0 5 5	1 1 5 3 7 8	7 1 6 9 7 1
6 3 3 8 4 4	7 3 8 2 8 0	8 4 6 3 7 0	9 1 0 6 4 8	6 9 5 1 1 8	3 1 1 4 0 6
3 1 0 9 6 8	4 8 7 5 3 6	3 9 3 0 9 4	5 0 5 9 6 0	2 2 6 4 6 4	4 8 2 1 5 0
1 1 3 9 3 5	6 1 3 5 0 7	4 2 5 4 6 2	1 5 7 4 0 9	2 2 5 7 7 4	8 2 1 2 2 2
8 5 1 5 3 0	2 0 7 0 9 5	3 7 3 8 7 4	2 7 3 4 3 9	9 9 6 5 3 6	2 8 5 2 0 4
1 5 0 5 6 8	1 7 0 8 7 5	4 8 7 7 5 7	7 4 7 8 1 9	7 4 3 1 8 3	5 3 9 7 6 0
7 2 6 1 7 7	4 3 7 1 9 5	5 9 6 5 3 0	0 7 0 5 3 9	2 6 9 2 6 5	0 8 7 8 4 6
6 7 9 0 1 2	8 1 2 1 7 4	2 9 0 0 5 4	3 5 4 9 8 8	9 3 2 1 5 9	5 8 5 3 5 6
4 6 4 8 7 2	5 5 7 4 3 5	4 7 6 3 1 7	3 5 2 9 1 1	4 8 4 0 0 5	8 7 0 7 5 9
6 0 2 1 1 2	5 8 7 9 8 7	3 0 0 5 3 4	9 1 1 1 8 5	8 6 3 9 6 1	6 3 9 9 1 7
3 7 6 1 5 0	2 6 3 4 4 6	2 0 7 1 5 2	7 3 8 6 6 8	9 4 8 4 1 1	2 5 4 3 7 3
7 3 5 6 3 2	1 5 0 0 0 5	1 4 2 2 7 4	9 1 6 3 5 4	6 0 0 7 1 8	2 7 1 4 7 1
2 0 4 3 5 4	1 2 5 8 5 4	5 2 8 8 6 2	3 5 6 2 6 4	6 8 8 1 8 2	8 2 4 3 7 6
0 0 1 5 5 7	5 2 8 1 7 8	1 8 2 8 2 1	6 9 2 6 9 3	5 4 2 2 9 5	2 1 8 0 4 3
0 0 9 4 0 9	9 3 3 1 8 0	0 1 8 0 4 1	9 5 3 3 7 4	4 6 3 1 0 0	4 8 0 5 6 1
1 1 4 9 1 9	3 3 9 5 4 2	2 9 1 1 2 4	6 0 7 1 1 1	2 0 4 5 8 4	7 6 6 2 8 2
3 7 9 6 0 2	6 6 0 3 5 0	7 8 0 6 2 8	1 3 7 9 7 0	0 4 7 9 4 3	7 5 0 6 0 2
3 3 0 2 4 8	9 9 1 7 1 3	4 2 2 2 8 4	0 1 5 1 4 7	1 6 5 3 0 6	1 1 7 6 8 8
2 2 0 5 8 8	8 4 8 4 0 5	1 7 1 7 7 8	4 7 6 7 9 2	5 8 4 9 5 4	3 5 6 0 6 9
0 4 9 9 8 9	5 5 3 2 1 2	4 4 9 2 7 9	7 4 2 8 3 9	6 6 1 4 3 9	4 6 0 0 0 5
2 7 9 7 0 0	4 6 7 8 0 8	7 0 7 3 2 3	8 0 0 8 6 9	8 3 5 4 7 1	3 1 2 9 6 1
1 5 5 9 3 9	2 2 4 9 2 8	4 5 3 6 7 6	1 8 8 0 4 0	5 5 6 9 5 6	2 2 0 4 2 7
0 1 7 8 0 7	7 0 6 1 6 4	7 6 1 2 2 5	6 6 5 1 2 3	9 8 7 7 6 6	7 8 1 1 9 5
5 5 3 4 2 7	1 8 4 4 5 7	5 2 4 4 7 0	3 5 8 9 2 6	9 1 6 3 9 5	5 0 9 8 3 5
0 1 6 1 6 8	7 5 5 0 5 1	3 8 4 5 4 6	9 7 2 7 6 5	9 2 8 8 5 7	8 6 2 5 3 9
8 5 1 5 2 4	7 3 1 3 7 1	8 3 3 0 5 3	6 0 5 4 9 7	5 5 4 0 6 3	5 4 9 4 3 7
2 0 4 9 1 7	7 8 4 0 6 8	6 4 1 8 7 8	2 8 0 8 8 8	4 3 5 3 3 2	6 7 4 0 6 4
1 5 1 4 9 3	9 3 1 3 4 6	0 5 6 2 2 2	5 6 5 8 2 1	0 8 7 2 7 7	2 0 4 7 3 4
9 0 8 7 2 8	9 1 1 7 9 6	8 5 7 0 9 2	6 1 1 0 4 2	9 3 7 8 5 6	3 5 1 5 9 2
0 4 1 7 7 6	4 6 6 1 9 0	1 2 9 3 2 4	6 7 6 8 0 4	5 2 7 1 9 7	2 9 2 3 5 3
1 3 8 0 3 9	8 1 4 8 5 8	7 5 9 6 6 2	3 8 3 7 3 3	6 6 2 6 0 9	7 9 9 7 0 5
3 2 9 0 7 1	6 6 4 2 1 8	6 0 6 2 4 3	7 2 7 3 4 4	7 4 9 8 1 3	8 5 9 2 1 7
4 0 6 4 7 3	4 3 9 9 9 8	0 3 2 3 8 2	3 8 8 9 7 8	6 6 4 9 2 2	3 4 0 3 1 8
5 4 8 2 3 1	8 4 9 9 0 9	6 7 6 3 7 7	8 1 0 2 4 1	3 5 5 6 3 0	0 5 0 1 2 5
3 7 8 8 6 6	9 0 0 3 4 0	5 5 5 9 2 5	3 1 3 0 4 1	5 8 8 9 9 0	6 0 0 3 1 3
0 1 8 8 9 3	1 3 0 7 8 3	7 2 5 1 2 3	7 0 5 1 3 4	3 1 8 5 2 5	5 4 7 9 1 7
4 5 2 2 5 1	3 7 3 4 3 1	1 9 5 6 6 7	6 4 4 0 6 1	2 6 8 2 2 2	8 7 7 2 0 4
3 6 2 6 6 2	3 3 0 3 7 9	9 3 0 3 2 4	2 7 5 9 7 1	7 6 6 0 1 0	8 6 2 5 8 5
6 2 6 3 6 4	1 9 7 3 3 8	6 5 7 9 7 2	8 6 4 9 7 8	2 3 1 2 1 5	9 4 7 6 2 1
1 8 3 7 0 1	1 9 9 8 3 8	4 0 9 7 9 2	3 3 3 2 3 3	6 3 1 9 4 9	7 2 4 2 9 0
0 9 8 0 4 6	6 5 5 4 1 8	4 6 9 7 2 1	9 7 7 7 3 0	4 6 3 2 5 9	2 3 1 1 2 2
1 1 9 0 4 1	5 5 0 0 8 8	9 9 9 5 6 0	2 1 9 6 5 4	2 2 1 9 7 8	0 2 5 3 3 7
5 1 7 1 4 3	3 8 6 5 0 5	5 7 5 7 2 7	9 6 3 1 5 9	9 1 8 9 7 7	3 0 4 0 9 4
6 6 1 3 6 6	3 4 3 5 1 9	5 9 5 8 2 2	8 5 6 8 1 9	1 9 6 5 6 1	9 6 8 4 8 6
7 1 3 9 3 3	7 1 4 8 4 2	0 8 2 9 2 9	5 9 5 4 2 1	5 8 7 1 9 2	0 6 9 3 8 3
0 0 6 8 4 7	6 6 9 3 6 0	7 7 8 2 8 2	6 6 5 2 0 4	3 7 3 9 8 2	2 0 5 8 0 7
5 9 0 9 0 7	6 6 2 3 6 2	4 7 4 4 8 6	0 1 9 8 0 4	9 7 7 4 7 4	9 4 0 7 8 2
3 9 5 4 1 4	9 4 7 0 1 1	0 4 8 1 2 1	3 1 8 6 2 2	4 8 9 7 5 4	0 8 8 3 9 8
7 2 9 8 1 9	8 2 0 3 7 8	2 7 0 0 2 1	9 5 6 4 5 5	2 6 2 6 1 7	9 5 8 0 0 5
6 4 5 9 1 5	5 5 5 0 0 1	2 9 3 0 8 6	0 9 8 1 9 5	2 8 4 8 7 6	4 6 9 8 8 1
0 3 9 8 7 6	7 6 8 3 8 4	9 1 1 6 0 5	4 3 9 1 6 6	1 1 3 8 2 4	2 1 4 4 3 5
8 5 0 3 9 8	8 7 9 8 5 4	7 0 9 3 9 3	5 4 4 7 1 9	2 4 0 1 8 0	8 0 1 0 8 6
1 1 7 7 6 6	9 0 6 7 0 1	4 2 5 9 5 5	0 1 0 1 5 2	4 7 1 3 1 2	4 7 9 9 5 7
1 3 6 0 7 3	7 7 5 0 0 6	8 8 2 3 1 0	9 0 0 1 3 6	8 0 8 6 6 2	0 2 9 4 0 5
3 1 4 8 7 2	5 0 3 9 3 8	5 5 7 3 8 3	2 0 9 4 4 4	0 0 5 5 8 9	6 5 2 1 1 5
6 1 9 0 9 6	8 7 5 8 7 5	9 0 2 4 7 1	4 5 6 2 3 9	8 6 7 7 8 9	1 1 1 8 9 5
0 2 4 8 6 0	2 2 6 6 9 2	6 1 7 2 5 0	2 3 4 2 1 4	6 8 9 9 3 0	5 5 6 2 5 5
9 8 2 3 6 3	0 2 5 9 1 2	6 2 4 4 3 4	9 1 3 8 7 5	6 4 5 8 9 2	5 2 3 4 4 6

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
MEAT AND POULTRY INSPECTION TECHNICAL SERVICES

RANDOM NUMBERS WORKSHEET

1st STEP	2nd STEP
SAMPLE UNITS / SAMPLE UNITS PER CASE = 228 / 3 = 76 CASES NEEDED	SAMPLE UNITS / SAMPLE UNITS PER CASE = 288 / 3 = 96 CASES NEEDED
CASES NEEDED / TOTAL PALLETS = 76 / 50 = 1 CASES PER PALLET PLUS 26 CASES	CASES NEEDED / TOTAL PALLETS = 96 / 50 = 1 CASES PER PALLET PLUS 46 CASES

PALLET NO.	NO. OF SAMPLE CASES		CASE NUMBERS SELECTED	
	1st	2nd	1st STEP	2nd STEP
1	2	2	37, 29	~~37~~, 1, 12
2	2	2	16, 4	33, 22
3	1	2	5	9, 29
4	2	2	13, 28	29, 44
5	2	2	11, 34	36, 29
6	1	2	10	37, 7
7	1	2	23	8, 22
8	2	2	13, 5	24, 40
9	1	2	30	13, 21
10	2	2	45, 20	3, 33
11	2	2	20, 33	13, 16
12	1	2	22	47, ~~22~~, 14
13	1	2	48	21, 18
14	2	2	14, 48	47, 2
15	1	2	4	48, 12

THIS ATTACHMENT REPRESENTS A COMPLETED WORKSHEET FOR EXAMPLE 1.0 (ATTACHMENT 2). IT HAS BEEN SHORTENED TO DEMONSTRATE THE METHOD YOU WOULD USE TO DETERMINE THE RANDOM NUMBERS NEEDED TO COMPLETE EXAMPLE 1.0.

40	1	2	24	38, 18
41	2	2	14, 40	25, 18
42	2	2	3, 46	15, 24
43	2	2	45, 44	25, 11
44	1	1	40	28
45	2	2	47, 25	27, 3
46	2	1	15, 41	~~15~~, 19
47	1	2	33	32, 31
48	1	2	2	27, 36
49	2	2	26, 34	9, 14
50	2	2	47, 23	31, 37

FSIS FORM 7520-2 (2/88)

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
MEAT AND POULTRY INSPECTION TECHNICAL SERVICES

RANDOM NUMBERS WORKSHEET

1st STEP	2nd STEP
SAMPLE UNITS / SAMPLE UNITS PER CASE = 228 / 6 = 38 CASES NEEDED	SAMPLE UNITS / SAMPLE UNITS PER CASE = 288 / 6 = 48 CASES NEEDED
CASES NEEDED / TOTAL PALLETS = 38 / 80 = ____ CASES PER PALLET PLUS 38 CASES	CASES NEEDED / TOTAL PALLETS = 48 / 80 = ____ CASES PER PALLET PLUS 48 CASES

PALLET NO.	NO. OF SAMPLE CASES		CASE NUMBERS SELECTED	
	1st	2nd	1st STEP	2nd STEP
1	1	1	14	25
2	0	1		16
3	1	0	1	
4	1	0	13	
5	1	1	8	16
6	1	0	14	
7	1	0	27	
8	0	1		17
9	0	1		24
10	1	0	19	
11	0	1		13
12	0	1		24
13	0	1		26
14	1	1	28	16
15	1	1	6	5

THIS ATTACHMENT REPRESENTS A COMPLETED WORKSHEET FOR EXAMPLE 2.0 (ATTACHMENT 2). IT HAS BEEN SHORTENED TO DEMONSTRATE THE METHOD YOU WOULD USE TO DETERMINE THE RANDOM NUMBERS NEEDED TO COMPLETE EXAMPLE 2.0.

70	0	1		17
71	1	1	7	20
72	0	0		
73	0	1		8
74	1	0	6	
75	0	1		14
76	0	1		24
77	0	1		1
78	0	1		5
79	0	1		15
80	1	0	23	

FORM 7520-2 (2/88)

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☒ AMENDMENTS
☐ OTHER

FSIS DIRECTIVE 7520.2--PROCEDURES FOR CONDITION OF CANNED PRODUCT CONTAINER EXAMINATION	7520.2 Amend. 1	9-8-88

I. **PURPOSE**

This document transmits revised pages 9 and 10 to FSIS Directive 7520.2, dated 5-12-88, and provides instructions to users.

II. **INSTRUCTIONS**

Remove	Insert
Pages 9 and 10	Pages 9, 9a, and 10

III. **CANCELLATION**

This change transmittal is cancelled when the changes have been completed.

Deputy Administrator
Meat and Poultry Inspection Operations

Attachments
Pages 9, 9a and 10--FSIS Directive 7520.2

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/PPID

CONDITION OF CONTAINER SCORE SHEET

A. LOT AND SAMPLE IDENTIFICATION

PRODUCT		CONTAINER CODE (S) / LOT NO	TYPE OF CONTAINER (Glass, metal, etc.)
SIZE OF CONTAINER (Net wt. and dimensions)	NO. OF CONTAINERS IN LOT	EST. NO. WHERE INSPECTED	PRODUCED AT EST. NO.
COMPANY NAME AND ADDRESS WHERE INSPECTED		TYPE OF INSPECTION ☐ Original ☐ Reinspection	SAMPLING PLAN ☐ Normal ☐ Tightened
		NO. OF SAMPLES: 1st Step	2nd Step	TOTAL

B. DEFECT DESCRIPTIONS (I) = Critical (II) = Major

B.1 - *Affecting All Container Types*

Defect No.	Crit. / Maj.	TYPE OF DEFECT	TALLY 1st Step	TALLY 2nd Step	Defect No.	Crit. / Maj.	TYPE OF DEFECT	TALLY 1st Step	TALLY 2nd Step
101	(I)	Swollen – Burst, Hard Swell, Soft Swell, Flipper or Springer. Loose Tin			105	(I)	Broken Score Line or Tearstrip		
102	(I)	Corrosion *(If Through Container Wall)*			106	(I)	Dents *(Fractures or Damage Impedes Exam)*		
201	(II)	Corrosion *(Severely Pitted, Not Through Container Wall)*			206	(II)	Dents or Panels *(Causing Body Creases or Affecting Seal or Score with No Cracks)*		
103	(I)	Buckle or Peak Into Seam *(Evidence of Leakage)*			107	(I)	Evidence of Leakage *(If No Other Criteria Apply)*		
202	(II)	Buckle or Peak Into Seam *(No Evidence of Leakage)*			108	(I)	Other Critical Defects–Explain *(If No Blocks Apply)*		
104	(I)	Cut Through, Fractures, Holes, or, Punctures *(Not on Seam or Seal)*			204	(II)	Other Major Defects–Explain *(If No Blocks Apply)*		

B.2–Cans with Double Seams

109	(I)	Incomplete Seam *(False, Knocked Flange / Cover)*			207	(II)	Vee, Spur, or Droop *(More Than 1 / 3 Seam Height, No Leakage)*		
110	(I)	Cut Seam or Abrasion Through One Layer of Seam			112	(I)	Deadhead, Skidder, Spinner, or Skip Seam		
205	(II)	Cutover / Sharp Seam *(No Evidence of Leakage)*			113	(I)	Side Seam Cracked or Opened Including Voids		
206	(II)	Cut Seam or Abrasion, Not Through One Layer of Seam			208	(II)	Mislocked Side Seam *(No Evidence of Leakage)*		
111	(I)	Vee, Spur, or Droop *(Evidence of Leakage)*							

B.3–Glass Jars

114	(I)	Loss of Vacuum			209	(II)	Damaged Seal Area (Cap) *(No Evidence of Leakage)*		
115	(I)	Missing, Loose or Cocked Cap			210	(II)	Glass Imperfections *(No Evidence of Leakage)*		
116	(I)	Broken, Fractured, Cracked Jar			211	(II)	Glass Bubble Exceeding 1 / 8 inch Diameter		
117	(I)	Damaged Seal Area (Cap) *(Evidence of Leakage)*			212	(II)	Product Under Cap *(Not Affecting Seal)*		

B.4–Flexible Containers with Heat Seals

118	(I)	Less Than 1 / 16 inch Continuous Defect-Free Seal			214	(II)	Severely Distorted		
213	(II)	Delamination in the Product Area Greater Than 1 / 16 inch							

REMARKS

DEFECTS	CRITICAL	CRITICAL AND MAJOR
1st Step		
2nd Step		
TOTAL DEFECTS		

HELD FOR LABORATORY ANALYSIS ☐ Yes ☐ No

LOT ☐ Accepted ☐ Rejected

SIGNATURE OF INSPECTOR

DATE

FSIS FORM 7520-1 (2 / 88) REPLACES FSIS FORM 8110-1 (8 / 86), WHICH MAY BE USED UNTIL EXHAUSTED. USDA-FSIS

SAMPLE COPY

FSIS FORM 7520-1 *(REVERSE)*

C. SAMPLING PLANS

Table 1

LOT SIZE (CONTAINERS)	SAMPLE SIZE (CONTAINERS)	CRITICAL DEFECTS (I)		TOTAL CRITICALS AND MAJORS			
				ORIGIN		DESTINATION	
NORMAL PLAN	2-STEP SAMPLING	AC	RE	AC	RE	AC	RE
6,000 or Less	1st Step 120	0	1	2	5	2	6
	2nd Step 60						
	Total 180	0	1	4	5	5	6
6,001-12,000	1st Step 168	0	2	1	5	2	7
	2nd Step 180						
	Total 348	1	2	7	8	9	10
12,001-36,000	1st Step 228	0	3	3	7	3	9
	2nd Step 288						
	Total 516	2	3	9	10	12	13
36,001 or Larger	1st Step 456	0	4	5	10	8	13
	2nd Step 408						
	Total 864	3	4	14	15	19	20
TIGHTENED	SINGLE SAMPLING						
6,000 or Less	300	0	3	5	6	6	7
6,001-12,000	475	1	2	8	9	11	12
12,001-36,000	630		3	10	11	14	15
36,001 or Larger	900		4	12	13	17	18

SAMPLE COPY

Table 2

CONTAINERS IN A CASE	MAXIMUM SAMPLE UNITS PER CASE
5 or Less	All
6-12	6
13-60	12
61-250	16
251 or More	24

DEFECT CLASSIFICATIONS:

(a) **Critical defect (I).** An abnormality which indicates that the container is not hermetically sealed *(e.g., holes, fractures, leakage)* or shows evidence that there may be spoilage of the container's contents.

(b) **Major defect (II).** An abnormality that may affect container integrity.

NOTE: IF SWOLLEN CONTAINERS *(Defect No. 101)* ARE FOUND AND THE CONTAINER(S) EXHIBITS NO OBVIOUS MECHANICAL DEFECT, THE LOT MUST BE HELD PENDING LABORATORY ANALYSIS. NOTIFY YOUR SUPERVISOR AND THE MICROBIOLOGIST-IN-CHARGE AT THE DESIGNATED FSIS LABORATORY. For establishments under a Total Quality Control (TQC) system or a Partial Quality Control (PQC) program per 9 CFR 318.309, follow those procedures.

Upon completion of the examination, file the original scoresheet and random numbers worksheet. Retain originals for 3 years.

EXAMPLES OF CONDITION-OF-CONTAINER EXAMINATION

Example 1.0 A lot of 28,800 metal cans is to be examined under the normal sampling plan. The lot is palletized and cased - 2400 cases (12 cans per case) arranged on 50 pallets each holding 48 cases. The sample size is 228 sample units (cans) for the first step. (See Section C of the Score Sheet for sampling plans.)

You have decided to take 1/2 of the maximum number of cans from a case permitted in Table 2 of the Score Sheet; that is, 3 cans from each case. The selection of 228 cans for the first step proceeds as follows:

1.1 How to determine the total number of cases to examine:

$$\frac{228}{3}\ \frac{\text{(sample units required)}}{\text{(No. of cans/cases to examine)}} = 76 \text{ (cases to examine)}$$

(228 ÷ 3 = 76)

If the number of cases to be examined is greater than the number of pallets, a case(s) will be drawn from each pallet.

1.2 How to determine the total number of cases per pallet to be examined:

$$\frac{76}{50}\ \frac{\text{(cases to examine)}}{\text{(No. of pallets)}} = \text{1 case per pallet plus 26 cases (1 more from each of 26 pallets)}$$

1.3 Designate numbers for each pallet from 1 through 50 on a Random Numbers Worksheet (See Attachment 4). Remember there are 48 cases on each pallet.

1.4 Draw 1 usable number (1 through 48) from the random number table. This indicates the case to be drawn from the first pallet. Repeat the process for each of the remaining 49 pallets.

1.5 Draw 26 usable numbers (1 through 50) from the random numbers table. These 26 numbers indicate the 26 additional pallets from which to select the additional cases.

1.6 Repeat the case selection procedure in 1.4, drawing 26 usable numbers to identify the 26 additional cases needed. (One case from each of the 26 pallets selected in 1.5.) Select another random number if a case number was previously selected for that pallet.

1.7 For 2nd step sampling, 288 cans are needed. Two cases from 46 pallets and 1 case from 4 pallets would be selected. Thus, select 4 random numbers from 1 through 50 to determine the four pallets from which only one case will be drawn. Draw two usable numbers (1 through 48) for

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE | 7630.1 | 2-4-88

APPROVAL OF CERTAIN PARTIAL QUALITY CONTROL PROGRAMS

I. PURPOSE

This directive provides formal authority to regional office personnel to approve certain partial quality control programs.

II. CANCELLATION

MPI Bulletin 84-5 Entitled "Approval of Partial Plant Quality Control Programs" and a letter dated August 8, 1985, from the Assistant Deputy Administrator, Regional Operations, MPIO, transferring approval authority to regional offices for the following partial quality control programs: Addition of Solution to Roast Beef, Addition of Solution to Cooked Beef, and Addition of Solution to Cooked Corned Beef.

III. REASON FOR ISSUANCE

[RESERVED]

IV. REFERENCES

Parts 316, 317, 318 and 319 of the Federal meat inspection regulations and Part 381, Subparts I, N, O, and P of the poultry products inspection regulations. Sections 17.10 and 17.14 and Part 18 of the Meat and Poultry Inspection Manual.

V. AUTHORITY TO APPROVE CERTAIN PARTIAL QUALITY CONTROL PROGRAMS

The authority to approve the following partial quality control programs is transferred to the regional offices:

1. Net Weight
2. Drained Weight
3. Fill Weight
4. Cooked Sausage Fat and Added Water
5. Cooked Sausage Added Water

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: TS/PPID

6. Grade Labeling
7. Vignette Labeling
8. Declared Count Labeling
9. Pickled Products Vinegar/pH Control
10. Dry Sausage Moisture/Protein Ratio
11. Boneless Meat Reinspection
12. Pork Skins for Popping
13. Foreign Material
14. Metal Detection
15. Rework Control
16. Roast Beef
17. Cooked Beef
18. Cooked Corned Beef
19. Beef Carcass AQL
20. Tenderizer Pickup
21. Basting/Marination
22. Batter and Breading
23. Microbiological Control and Monitoring Program
24. Product Identification Labeling
25. Chlorinated Water Spraying Control
26. Potable Water Spraying Control
27. Addition of Solution to Roast Beef
28. Addition of Solution to Cooked Beef
29. Addition of Solution to Cooked Corned Beef
30. Raw Product Fat and Moisture Control
31. Ground Beef Fat Control
32. Fresh Pork Sausage Fat and Moisture Control
33. Pumped Corned Beef
34. Addition of Solution to Pork Products
35. Marination of Red Meat
36. Pumped Poultry
37. Addition of Solution to Poultry
38. Percent Meat Washout
39. Precooked Breakfast Sausage Yield Control
40. PFF Added Substance Control
41. Cured Pork Products - Control of X% Added Ingredient

VI. OTHER INFORMATION

A. The processor is given wide latitude in the development and format of written quality control programs. It is not necessary or desirable that they follow a specific format as long as all regulatory requirements are addressed.

B. The Regional Quality Control Specialist will evaluate partial quality control programs to assure all regulatory requirements are met using the regulations, appropriate guidelines and other pertinent information.

C. One copy of the approval letter and the partial quality control program should be sent to the Processed Products Inspection Division (PPID) for entry into PPID's inventory listing. PPID periodically audits approved partial quality control programs for adequacy, completeness, uniformity and consistency.

D. Guidelines for the preparation of the above listed partial quality control programs are available from the regional offices.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

8080.1 REV. 1	1-13-88

RECALL OF INSPECTED MEAT AND POULTRY PRODUCT

I. PURPOSE

This directive provides procedures for the recall of meat and poultry products subject to the jurisdiction of the Food Safety and Inspection Service (FSIS).

II. REASON FOR REISSUANCE

The purpose for revising this directive is twofold as follows:

A. To amend references to program names.

B. To update Section VII, M., Effectiveness Reviews, to include discussion on reviews being conducted in accordance with the Compliance Program procedures on recall.

III. CANCELLATION

FSIS Directive 8080.1, dated 8/4/83.

IV. [RESERVED]

V. ABBREVIATIONS

The following abbreviations will be used throughout the directive:

FSIS	Food and Safety Inspection Service
MPI	Meat and Poultry Inspection
EP	Emergency Programs Staff
MPIO	Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, TRA, ABB, R&E, AID, Science Offices, Compliance Offices

OPI: MPIO/EP

VI. POLICY

A. Recalls are actions to effect the removal of product from trade and/or consumer channels. Recalls are voluntary actions by manufacturers and/or distributors to protect the public health from products that are adulterated or misbranded. A recall may be an alternative to an FSIS detention or seizure action to remove or otherwise correct violative, distributed products. +[Therefore, although recalls are voluntary, FSIS must oversee all such recall activities and coordinate any FSIS actions with the recall taken by the manufacturing distributor.]+

B. A recall may be undertaken at any time by a manufacturer or distributor on its own initiative, or at the request of FSIS. A request by FSIS that a firm recall a product is reserved for urgent situations and is to be directed by FSIS to the firm that has primary responsibility for the manufacturing and marketing of the product that is to be recalled. In all cases involving firm-initiated recalls, the firm is requested to notify the Regional Director, FSIS, or other inspection personnel in the region where the establishment is located within 24 hours of the firm's initiating action to recall a product from the marketplace.

C. FSIS will give recalls priority attention at all levels of the Agency and will:

1. Assess the public health hazard presented by a product being recalled, or considered for recall, whether firm-initiated or requested by FSIS, and classify it as one of the following:

a. Class I. Involves a health hazard situation where there is a reasonable probability that the use of the product will cause serious, adverse health consequences or death.

b. Class II. Involves a potential health hazard situation where there is a remote probability of serious, adverse health consequences from the use of the product.

c. Class III. Involves a situation where the use of the product is not likely to cause adverse health consequences.

2. Initiate the following FSIS recall oversight under the following circumstances:

a. When the firm initiates the recall, by reviewing their recall strategy and suggesting changes as deemed necessary, and coordinating with them any action taken or planned by FSIS.

b. When FSIS requests the recall, by notifying the firm and by confirming in writing FSIS's determination of the need to immediately begin a recall. Such notification will specify the violation, the health hazard classification, the recommended recall strategy and any other instructions appropriate to the conduct of the recall.

3. Monitor the recall operation by developing and implementing a recall monitoring program which will include:

a. Reviewing periodic recall status reports received from the recalling firm and/or reviewing documentation of the recall operation and its effectiveness during visits to the firm.

b. Conducting effectiveness reviews to verify that consignees have received notification and have taken appropriate action.

c. Reviewing the recall firm's determination as to when its recall is complete and providing written notification to the firm when FSIS officially terminates its recall oversight.

4. Maintain working relationships with other Federal, State and local agencies, and foreign governments for the purpose of obtaining information and cooperation in recall situations.

5. Pursue, if necessary, legal action and/or other measures.

VII. DEFINITIONS

A. **Recall.** The voluntary removal by a firm from commerce of distributed meat or poultry products when there is reason to believe that such products are adulterated or misbranded under the provisions of the Federal Meat Inspection Act or the Poultry Products Inspection Act. "Recall" does not include a market withdrawal or a stock recovery.

B. **Correction.** The firm's modification, relabeling, or destruction of a product with the concurrence of FSIS.

C. **Recalling Firm.** The firm that initiates a recall or, in the case of an FSIS-requested recall, the firm that has primary responsibility for the manufacturing and/or marketing of the product to be recalled.

D. **Firm-Initiated Recall.** A recall that is initiated by a firm without a formal request from FSIS.

E. **FSIS-Requested Recall.** A recall initiated by a firm in response to a formal request from FSIS.

F. **Case Number.** The number or code assigned to the recall incident for use by FSIS to identify the investigation or product recall.

G. **Health Hazard Evaluation.** An evaluation of the health hazard presented by a product being recalled or considered for recall. The evaluation will be conducted by a team of FSIS experts with access to other individuals or agencies as deemed necessary.

H. **Emergency Programs Team.** A team of representatives from various FSIS divisions and staffs assembled to respond to potential or real health hazard incidents reported to EP. Representatives from the following Agency units may be members of the team: Chemistry Division, Compliance +[Program,]+ Emergency Programs Staff, Epidemiology Branch, Export Coordination Staff, Foreign Programs Division, Field Service Laboratories Division, Mathematics and Statistics Division, Import Inspection Division, Information and Legislative Affairs, Microbiology Division, +[Residue Operations Staff,]+ Processed Products Inspection Division, Residue Evaluation and Planning Division, and +[Regional Operations, MPIO.]+ The team may be activated by the Director, EP, whenever deemed necessary, and its members will report to the Director, EP, for the purpose of conducting assignments related to the health hazard incident.

I. **Recall Strategy.** The action plan recommended by or to the recalling firm and followed by FSIS in monitoring a recall.

J. **Depth of Recall.** The level of product distribution to which the recall is to extend:

1. Consumer or user level including any intermediate wholesale or retail level.

2. Retail level - the level immediately preceding the consumer or user level.

3. Wholesale level - the distribution level between the manufacturer and the retailer. This level may not be encountered in every recall situation; i.e., the manufacturer may sell directly to the retail outlet.

L. **Public Notification.** The purpose of a public notification is to alert the public and trade that either product is being recalled because it presents a serious health hazard, or because a situation exists for which such notification is deemed to be in the public interest. Each recall will be considered on a case-by-case basis as to the necessity for public notification; provided, however, that all Class I recalls will result in the issuance of a press release or other form of public notification, unless so exempted by the Administrator, FSIS. The situations where this exemption will be permitted are (1) when there is sufficient data to support the conclusion that the suspect product in commerce is under control by FSIS or that of another Federal or State agency, and that the likelihood that any product is in the hands of consumers is extremely remote, or (2) when public notification has already been made by another government agency (State or Federal) and for which the text, format, and method of notification is acceptable to FSIS. However, information on any recall action of any classification will be made available to the public or press when inquiry is made, provided that such information is not exempt under the Freedom of Information Act.

M. **Effectiveness Reviews.** The purpose of effectiveness reviews is to verify that adequate notice about the recall has been provided to all consignees. Adequacy of notice is determined by the degree to which implicated product is in fact retrieved by or on behalf of the official establishment and is properly disposed of. The number of effectiveness reviews to be conducted will be determined on a case-by-case basis by the Assistant Deputy Administrator, Compliance Program. +[The reviews will be conducted in accordance with Compliance procedures]+ and will focus upon the following elements:

1. Recall level.

2. Health hazard.

3. Initial effectiveness review findings.

4. Recall firm's actions.

A sufficient number of effectiveness reviews will be made to provide assurance that the recall action is conducted in an effective manner, and that appropriate efforts are made to locate and return the product being recalled.

+[In the event that effectiveness reviews disclose recalled product remaining in commerce, the recalling firm must be notified. If the firm does not take prompt action to properly

dispose of the product, the Assistant Deputy Administrator, Compliance Program, may detain and seize product or initiate other action as appropriate.]+

N. **Monitor.** To observe and record data concerning a firm's recall and to conduct effectiveness reviews.

O. **Recall Evaluation.** The evaluation of final reports after recall action is completed to determine the recall's effectiveness. The evaluation will include the percent of product returned, its disposition, and the number and level of consignees reviewed. The recall evaluation will form the basis for terminating the recall.

P. **Termination of a Recall.** A recall will be considered officially terminated when the Agency determines that all reasonable efforts have been made to remove or correct the violative product, and proper disposition has been made according to the degree of hazard. For monitoring purposes, FSIS will classify a recall action "completed" at the time when the firm has actually retrieved and impounded all outstanding product that could reasonably be expected to be recovered, or has completed all product corrections.

Q. **Market Withdrawal.** Market withdrawal means a firm's removal or correction at its own volition of a distributed product which involves a minor infraction that would not warrant legal action by FSIS or which involves no violation of the FMIA or PPIA or health hazard.

R. **Stock Recovery.** Stock recovery refers to a firm's removal or correction of product that has not been marketed or that has not left the direct control of the firm; i.e., the product is located on premises owned by, or under the control of, the firm and no portion of the lot has been released for sale or use.

VIII. RECALL PROCEDURES

The purpose of these steps is to assure that a recall is conducted in a manner that achieves the orderly return or other appropriate disposition of violative product to the extent necessary to protect the consuming public from products that present real or potential health risks or gross consumer deception. These steps include:

A. **Health Hazard Evaluation.** An evaluation of the health hazard presented by a product being considered for recall, or being recalled, will be conducted by a team of FSIS experts in cooperation with other individuals or agencies as deemed necessary. The evaluation will include at least the following factors:

1. Nature of the violation or defect.

2. Whether any illnesses or injuries have already occurred from the use of the product.

3. Assessment of the likelihood of occurrence of the hazard.

4. Assessment of the consequences (immediate or long range) of occurrence of the hazard.

B. Recall Classification. A recall classification will be assigned to product recalls based on the health hazard evaluation, or the assessment of the nature of the deception or other defect. FSIS will assign the classification, i.e., Class I, Class II, or Class III, to indicate the relative degree of health hazard of the product being considered for recall or being recalled.

C. Recall Strategy.

1. A recall strategy will be developed to assist in the conduct of a recall. The strategy takes into account the following factors:

a. Recall classification assigned by FSIS.

b. Depth of recall.

c. Extent of notification being made to the trade or public.

d. Action plan to coordinate the removal and return or correction of the product from the marketplace.

e. Effectiveness reviews.

2. Elements of a recall strategy will include:

a. Results of the health hazard evaluation.

b. Ease in identifying the product.

c. Degree to which the product's deficiency is obvious to the consumer.

d. Degree to which the production remains unused in the marketplace.

e. Amount of product involved.

f. Area of distribution.

g. Action taken or planned by the recalling firm.

D. **Recall Recommendation.** The EP Staff will prepare the Recall Recommendation for submission to the Deputy Administrator, MPIO. The Recall Recommendation will include:

1. Health Hazard Evaluation.

2. Recall Classification.

3. Recall Strategy.

E. **Recall Request.** The Recall Recommendation will be reviewed by the Deputy Administrator, MPIO. The final decision to request a product recall is made with the concurrence of the Administrator, FSIS. After the decision to recall, the Deputy Administrator, MPIO, or designee will contact the firm to make the formal request for a recall. The appropriate Federal, State, and local agencies are notified of the product recall.

F. **Termination of Recall.** A recall will be considered officially terminated when FSIS determines that the recall action is completed, proper disposition has been made of the violative product, and that no further emergency action is pending. The Director, EP, will assemble the information and reports necessary to make this determination, and will make the recommendation for terminating the recall to the Deputy Administrator, MPIO. The recommendation will be reviewed by the Deputy Administrator, MPIO.

The final decision to terminate a recall is made with the concurrence of the Administrator, FSIS. The recalling firm and the appropriate Federal, State, and local agencies are then notified by FSIS of the recall termination.

Administrator

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

8410.2 | 6-3-88

INTENSIFIED REGULATORY ENFORCEMENT

I. PURPOSE

This directive prescribes policy and procedures for applying more intensive regulation to establishments that have a poor history of compliance with Federal regulations or that are marginal in their operating practices.

II. (RESERVED)

III. (RESERVED)

IV. REFERENCES

General provisions of the Federal Meat Inspection Act (FMIA), the Poultry Products Inspection Act (PPIA), and Meat and Poultry Inspection Regulations.

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated in this directive:

ADA	Assistant Deputy Administrator
AFGE	American Federation of Government Employees
CP	Compliance Program
FMIA	Federal Meat Inspection Act
FSIS	Food Safety and Inspection Service
GAO	General Accounting Office
IIC	Inspector In Charge
IRE	Intensified Regulatory Enforcement
MPIO	Meat and Poultry Inspection Operations
OIG	Office of the Inspector General
PPIA	Poultry Products Inspection Act
RO	Regional Operations

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, A'D, R&E, ABB, TRA

OPI: MPIO

FSIS Form 8410-1 IRE Plan of Action Cover Sheet
FSIS Form 8410-2 IRE Staffing
FSIS Form 8410-3 IRE Plan of Action
FSIS Form 8410-4 IRE Log

VI. POLICY

A. **It is FSIS' responsibility** to enforce the FMIA and PPIA so that establishments subject to the FMIA and PPIA comply with all applicable requirements of the laws and produce only safe, wholesome, and properly labeled meat and poultry products in a sanitary environment. FSIS carries out this responsibility through inspection of establishments' products, practices, and conditions that may effect those products and by undertaking enforcement actions when appropriate. Failure of establishments to comply with provisions of the FMIA and PPIA and the regulations promulgated thereunder may, in appropriate cases, result in refusal, suspension, or withdrawal of inspection services and/or the imposition of criminal or civil sanctions.

B. **It is FSIS policy** to intensify inspection and to take other actions as may be necessary to enforce the laws. In this regard, FSIS has a policy of applying intensified regulatory enforcement (IRE) to establishments that have a history of noncompliance.

C. **The objective** of intensified regulatory enforcement is to establish an environment in which establishment management achieves and maintains consistently acceptable operating practices. To achieve this objective FSIS applies procedures for: the identification and designation of IRE establishments, the application of intensified inspection and regulation, and the termination of IRE designation when establishment voluntary compliance has been achieved.

VII. CRITERIA FOR IRE DESIGNATION

A. **General.** Establishments meeting criteria for IRE fall within several categories of non-compliance, such as criminal violators, management unwilling or unable to conduct operations in compliance, and insanitary or otherwise unacceptable facilities and equipment. The basis for designation is a profile of the establishment's operational and compliance history.

B. **Factors for Consideration.**

1. Designation as an IRE establishment normally requires a documented history of recurring deficiencies. This profile must demonstrate that any previous steps taken to bring about corrective action have not resulted in sustained, voluntary establishment compliance. The establishment's operational and compliance history must demonstrate that the documented deficiencies continue to exist and represent current failures.

2. There may be a pattern of willful or aggressive resistance to FSIS regulatory efforts. This, either with or without documented deficiencies, would make a compelling case for IRE designation.

3. IRE status may be based on convictions or investigative records which show disregard for the law.

4. The initial decision to place a plant in an IRE status is based on judgments and assessments made by the Regional Director. The final decision to place or continue an establishment in IRE status requires the concurrence of the FSIS Administrator.

C. **Data Sources Used.**

1. IRE designation will usually be determined by information from records developed during routine and special regulatory activities as well as from outside sources.

2. Examples of the records collectively considered are:

a. Establishment reviews;

b. Laboratory product sample results;

c. Evaluation incidents and warning letters prepared by the Compliance Program;

d. Sanitation reports and history;

e. Product handling violations;

f. Delistments by foreign countries;

g. OIG and GAO reports;

h. Convictions;

i. Import/Export records;

j. Consumer and other complaints;

k. Letters written by Area Supervisor, Circuit Supervisor or IIC.

l. Other miscellaneous sources and records.

VIII. ENTRY INTO IRE PROGRAM

A. **Identification of Potential IRE Establishments.** The identification of potential IRE establishments may occur through a variety of means and may be informally recommended by any program employee. Formal recommendation for IRE status of an establishment will be made to the Deputy Administrator, MPIO, by the Regional Director.

B. **Regional Director Review.**

1. The Regional Director will review all available documentation regarding a recommendation by any subordinate supervisory level that an establishment be inspected under IRE.

2. The documentation will be drawn from the data sources identified in Section VII of this directive.

3. The Regional Director may also initiate a special on-site review, in conjunction with a documentation review, to assess any efforts undertaken by establishment management to correct noted deficiencies. Special reviews may be conducted by Agency officials or referred to authorized investigative officials, as appropriate.

4. When, in the Regional Director's judgment, the establishment's operational and compliance history, as reflected in the documentation review, reflects a sustained history of recurring and chronic problems, a confirmed pattern of neglect, or resistance to inspection requirements, the Regional Director submits the documentation and a recommendation for initiation of an IRE program to the MPIO Deputy Administrator.

C. **Headquarters Review.**

The Deputy Administrator reviews the recommendation for initiation of an IRE program in the affected establishment, including all relevant documentation regarding the establishment's operational and compliance history. If the MPIO Deputy Administrator concurs, he makes the determination that IRE should be implemented, subject to the Administrator's approval, and informs the Regional Director.

IX. FORMAL DESIGNATION

A. **Notification to Establishments.**

1. The Regional Director notifies the establishment by certified letter identifying the reasons for FSIS' determination that the establishment be placed in an IRE status and that intensified inspection is to be initiated in the establishment on or after a specified date. The letter will advise that the establishment may request a hearing on the reasons for the determination within 10 days of receipt of the letter.

2. The establishment may have an expedited informal hearing, either at the regional office, with the Regional Director, or at the headquarters office, with the MPIO Deputy Administrator or his designee as may be requested by the establishment.

B. **Notification to Inspection Personnel.**

1. The Regional Director will notify field supervisory and affected inspection personnel of an establishment designation under the IRE program.

2. The MPIO Regional Director will also contact appropriate AFGE Council President(s) to advise them that IRE status is being invoked in an establishment where bargaining unit members are assigned.

X. PLAN OF ACTION

A. Development of Plan of Action.

1. The Regional Director will identify and designate an inspection team consisting of, among others, inspection personnel assigned to, and supervisory personnel with responsibility for, the IRE plant during the term of IRE designation. Additional FSIS personnel may be included as appropriate to the circumstances leading to the IRE designation. Team members may include:

a. Inplant inspection personnel;

b. IIC;

c. Circuit Supervisor;

d. Area Supervisor;

e. Regional Director or his Deputy;

f. Headquarters representative(s);

g. Compliance Program representative;

h. Regional facilitator;

i. Relief inspectors when applicable;

j. AFGE representative(s).

The team members will be identified on Form 8401-1. (See Attachment 1.)

2. A plan of action for the application of more intensive inspection at the establishment is to be developed by the inspection team in accordance with an instructional guide which will be made available during the meeting. The plan of action will identify problems and causes and will provide possible solutions and specific corrective actions to be taken by the establishment and/or inspection personnel. The Plan of Action is documented on FSIS Form 8401-3. (See Attachment 3.)

B. Staffing and Coverage Strategies.

1. The Regional Director may make necessary staffing adjustments (inspector, inspector in charge, circuit supervisor, etc.) to assure compliance.

2. As the plan of action is developed, the need for additional inspector(s) or supervisor(s) may become apparent. If such is the case, the Regional Director will arrange for details of qualified inspection personnel into the establishment as indicated in the plan of action and recorded on FSIS Form 8401-2. (See Attachment 2.)

3. If the establishment is in a rotation pattern, it is to be removed from rotation while it remains in the IRE status. Intra-establishment rotation, however, may continue, subject to inspection actions identified in the plan of action. Appropriate consultations on such assignment changes of bargaining unit employees are to be conducted with union officials as provided for in the bargaining agreement.

C. **Interface with other FSIS Units.**

Close contact will be maintained with field Compliance Program Officers-in-Charge during development of the plan of action to identify monitoring and surveillance actions that are required outside the establishment in support of the plan of action. Compliance Program officials will be responsible for documentation of enforcement actions taken on incidents observed outside the establishment, and communicating them to Regional Directors.

XI. MONITORING/ASSESSMENT OF IRE ACTIVITIES

A. **Term of IRE Program.** The normal term of the IRE program is 6 months. This term may be shorter if the plant demonstrates substantial compliance after a 3-month mid-term assessment. However, the IRE term may be extended beyond the 6-month period if FSIS determines there is not substantial compliance and/or other reason(s) for the establishment to be continued in an IRE status.

B. **Documentation.**

1. Inspection personnel will utilize official inspection forms, memoranda, and IRE Log, FSIS Form 8401-4, (Attachment 4) to document observations, discrepancies, corrective actions initiated by the establishment and inspection actions taken. The use of such documentation sources is identified in the plan of action. The IRE Log, FSIS Form 8401-4, (Attachment 4), should:

a. Serve as documentation of plan of action activities.

b. Be reviewed by program supervisory levels whenever an establishment visit is conducted.

c. Be evaluated at one or more times during the IRE term, and may be used to initiate compliance inquiries leading to legal or administrative sanctions.

2. The IRE plan of action represents FSIS' approach to intensifying regulatory efforts in that establishment. The plan of action and the IRE log are confidential and are to be secured in the Government Office. The IIC is responsible for verification of entries made by other inspector(s). This can be accomplished by initialing the entry. The IIC is also responsible for the security of the plan of action and log.

3. Record retention for IRE files is 3 years and they are kept at the appropriate Regional Office for the duration of the retention period.

C. **Periodic Assessments.**

1. The plan of action should provide for periodic on-site assessments of the establishment by the circuit, area and regional levels. As a minimum, the plan should provide for assessment at 3-month intervals at the regional level. The on-site regional level assessments should be conducted by the Regional Director or Deputy Regional Director. The report of the quarterly assessment, together with copies of reports generated by the Area and Circuit Supervisor's periodic on-site assessments, and copies of the appropriate pages of the log and other documents that contain significant documentation, should be sent to the Assistant Deputy Administrator, RO, within 10 days following the quarterly review. The Regional Director's report should include an assessment and recommendation concerning the status of the IRE program.

2. Headquarters RO will evaluate the quarterly documentation, the Regional Director's assessment and recommendation, and information from CP concerning any pending legal actions. Headquarters RO will draft a letter for the Regional Director's signature advising establishment officials of their progress and/or continuing deficiencies and IRE status.

3. Revising the Plan of Action. The Regional Director may reconvene a meeting of the inspection team to revise the plan of action, whenever, in his/her judgment, it is necessary. The need to reconvene the inspection team may also be stimulated by conditions observed during establishment reviews by higher supervisory levels; information concerning criminal or investigative actions, or civil litigation involving establishment or establishment management officials; changes in FSIS supervisory personnel; or the assignment of additional inplant or relief inspection personnel.

4. Continuing Term Review. If an establishment is retained in an IRE status beyond the initial 6-month term, an assessment will be conducted at least every 3 months. The review will be conducted by the Regional Director or designee. Establishment operational and compliance history will be assessed since the prior review and a recommendation made either to continue the establishment in an IRE status or to return the establishment to normal regulatory inspection. Continued noncompliance under IRE can result in the withdrawal of inspection.

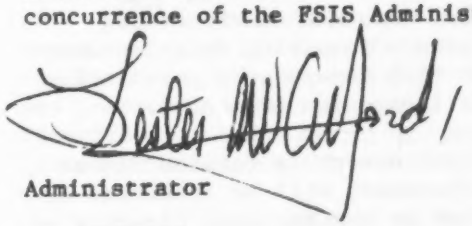
XII. EXIT FROM IRE PROGRAM

A. **The Regional Director.** May recommend an establishment's removal from the IRE program, in writing, following any quarterly assessment. The decision to return an establishment to normal regulatory inspection may require evaluation of investigative or legal documentation or issues not available at the regional level. The Assistant Deputy Administrators, CP and RO, are responsible for review and incorporation of such information. The recommendation, by either the Regional Director or one of the ADA's, is forwarded to the MPIO Deputy Administrator for his/her decision, subject to the approval of the FSIS Administrator.

B. **Notification of Termination of the IRE Program.** Upon concurrence with the recommendation for termination, headquarters RO will draft a letter for the Regional Director's signature notifying the establishment of its removal from the program. Prior to issuance of the IRE removal letter, the Regional Director may arrange an IRE exit meeting with the inspection team to discuss accomplishments of the effort and develop a post IRE action plan to assure continued compliance. The Regional Director will notify establishment management officials by certified letter of FSIS' determination that the IRE program is being terminated.

C. **Post-IRE Review.** To assure that an establishment continues to maintain standards of substantial sustained compliance which were achieved during the IRE term, a follow-up review will be conducted approximately 3 months following the end of the IRE term. The review will be conducted by the Regional Director or his/her designee. An independent review by the Review and Evaluation Staff will be conducted anytime within 6 months of IRE removal.

D. **Reinstatement of IRE Program.** FSIS may reinstate the IRE program in any establishment that had been so designated previously if the establishment fails to maintain the level of compliance achieved during the IRE term. It is not necessary to develop a completely new history of deficiencies after completion of the initial IRE term to substantiate a reinstatement of the IRE program. The process of reinstatement follows the procedures outlined in Section VIII of this directive. The MPIO Deputy Administrator approves or disapproves the recommendation for reinstatement of an IRE program in the affected establishment. The decision to reinstate an IRE program requires the concurrence of the FSIS Administrator.



Administrator

ATTACHMENTS

1 FSIS Form 8410-1, IRE Plan of Action Cover Sheet
2 FSIS Form 8410-2, IRE Staffing
3 FSIS Form 8410-3, IRE Plan of Action
4 FSIS Form 8410-4, IRE Log

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE

IRE PLAN OF ACTION COVER SHEET

ESTABLISHMENT NAME	ESTABLISHMENT NUMBER	REGION / AREA / CIRCUIT CODE
PLANT LOCATION (City, State)	ENTRY TO IRE STATUS (date IRE plan of action implemented)	3-MONTH REVIEW (target date)
6-MONTH REVIEW (target date, if applicable)	EXIT FROM IRE STATUS (date)	3-MONTH FOLLOW-UP REVIEW (target date)

INSPECTION TEAM

NAME AND TITLE (Print)	SIGNATURE	DATE

SAMPLE COPY

FSIS FORM 8410-1 (4/88)

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE

IRE STAFFING

ESTABLISHMENT NAME	ESTABLISHMENT NUMBER

TYPE OF OPERATION:
☐ SLAUGHTER ☐ PROCESSING ☐ COMBINATION (Slaughter / Processing)

INSPECTION PERSONNEL ASSIGNED TO THE PLANT (Prior to IRE review)

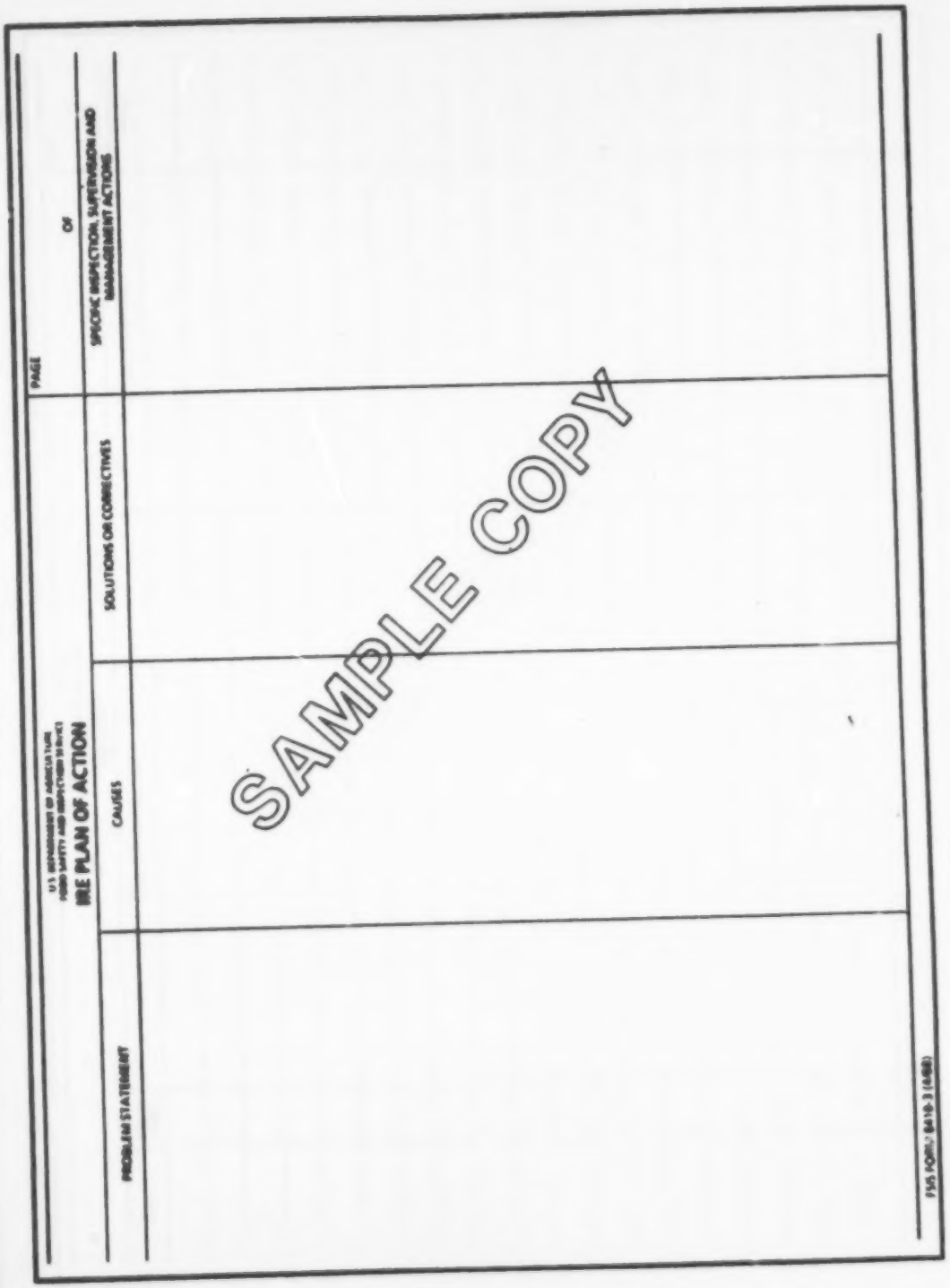
SAMPLE COPY

INSPECTION COVERAGE (IRE review)

ARE ADDITIONAL INSPECTION RESOURCES NEEDED? ☐ NO ☐ YES

If yes, briefly explain name, title, series, and grade of additional inspection personnel assigned to IRE plant.

PHS FORM 8410-2 (4/88)


U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
IRE PLAN OF ACTION
PAGE
OF
PROBLEM STATEMENT
CAUSES
SOLUTIONS OR CORRECTIVES
SPECIFIC INSPECTION, SUPERVISION AND MANAGEMENT ACTIONS
FSIS FORM 8410-3 (4/88)

SAMPLE COPY

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE

PAGE ___ OF ___

IRE LOG

DATE	IRE PA PAGE	OBSERVATION / ACTION	RESULTS OF ACTION	INSPECTOR / IC INITIALS

SAMPLE COPY

FSIS FORM 8410-6 (6/89)

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

8810.1 | 9/21/88

INSTRUCTIONS FOR COMPLETING FSIS FORM 8810-1, PLANT PROFILE

I. PURPOSE

This directive transmits FSIS Form 8810-1, Plant Profile, dated July 1988 and instructions for completing the form.

II. [RESERVED]

III. [RESERVED]

IV. REFERENCES

Federal Meat Inspection Act;
21 U.S.C. 601 et seq.;
Poultry Products Inspection Act;
21 U.S.C. 451 et seq.;
MPI Regulations, 9 CFR, Chapter 3;

V. ISSUANCE OF THE PLANT PROFILE FORM

The Plant Profile Form, Attachment 1, is used to collect information necessary to implement the Performance-Based Inspection System (PBIS) and to update files of the Common On-line Reference for Establishments (CORE). Instructions for completing the form are contained in Attachment 2.

DISTRIBUTION: All MPI Offices, Hq & Field Compliance Offices, ICL,

OPI: PPID/TS

READEX FICHE best copy available

Procedures for updating data collected on this form will be developed and incorporated into future revisions of this directive.

Administrator

Attachments

1 - FSIS Form 8810-1
2 - Plant Profile Instructions

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE

PLANT PROFILE

INSTRUCTIONS: There are three pages to this form. All three pages MUST be completed. Complete ALL blocks or indicate N/A when not applicable.

PLANT NAME, AND LOCATION ADDRESS (1)

ZIP CODE [ ] X [ ] Y [ ]

MAILING ADDRESS (*if different*), AND PLANT TELEPHONE NO. (1a)

INSPECTION SYSTEM (2)
☐ TQC ☐ ISWP

TYPE OF PLANT (3)
☐ Federal ☐ TA ☐ State

QUARTERLY VOLUME (*in pounds*) (4)

REGION NAME / NO. (5)

AREA NAME / NO. (6)

CIRCUIT NAME / NO. (7)

ESTABLISHMENT NO. (*Meat*) (8)

ESTABLISHMENT NO. (*Poultry*) (8)

APPROVED OPERATING HOURS (9)

SHIFT 1 START	SHIFT 1 FINISH	DAY	SHIFT 2 START	SHIFT 2 FINISH
		SUNDAY		
		MONDAY		
		TUESDAY		
		WEDNESDAY		
		THURSDAY		
		FRIDAY		
		SATURDAY		

Check applicable box(es) (10)
☐ Slaughter/Processing Combination (10a) ☐ Pure Processing (10b) ☐ Custom Exempt Operation (10c) ☐ Retail Exempt Operation

PRODUCTION AREA (*Sq. Ft.*) (11)

COMPLEXITY (*First Shift*) (12)

COMPLEXITY (*Second Shift*) (12)

PLANT MANAGEMENT NAMES (*If more space is needed, use reverse*) (13)

POSITION	FIRST SHIFT	SECOND SHIFT
President/General Manager		
Production Supervisor		
Foreman and Department		
Foreman and Department		
Foreman and Department		

Check, if appropriate:
☐ QC Manager ☐ QC Technician ☐ Additional Foreman

FEDERAL, STATE, LOCAL REQUIREMENTS (*Certificates, Letters, Permits, Etc.*) (14)

ITEM	WATER CERTIFICATE DUE DATE	CURRENT CERTIFICATE ON FILE YES ( )	DATE	NO ( )	N/A ( )
Potable Water Source ☐ Municipal ☐ Well(s)					
Sewage and Back flow					
Shipping Inedible Materials *(if applicable)*					
Ice Potability *(outside supplied)*					
Other *(specify)*:					

LIST GOVERNMENT OFFICE FACILITIES AND SERVICES (*location, security file, restroom/locker, laundry facilities, Electronic coded entry, etc.*) (15)

SPECIAL TELEPHONE CODES (*include area codes*) (16)

FSIS DESIGNATED PARKING SLOT: (*If yes, give location and/or slot number*)
☐ YES ☐ NO (17)

PRODUCT AND OPERATIONS PROFILE

PRODUCT / PROCESS ACTIVITIES AT THIS PLANT *(Place an "X" in all appropriate blocks)*

18

I

- ☐ Boning / Grinding
- ☐ Boneless Meat Reinspection
- ☐ Breaking / Cutting
- ☐ Chopping / Dicing
- ☐ Cracking / Skin popping
- ☐ Denaturing / Tanking
- ☐ Freezing
- ☐ No glazing parts
- ☐ Labeling / Packaging only
- ☐ Raw meat / poultry patties (without extenders)
- ☐ Poultry cut-up (RTC)
- ☐ Portion control
- ☐ Rendering - refining (edible animal fats, margarine, lard)
- ☐ Rendering (inedible)
- ☐ Basting
- ☐ Exports
- ☐ Tenderizing (mechanical other than massaging)
- ☐ Batter / breading
- ☐ Veal and Calf Skinning
- ☐ Freeze drying
- ☐ Injecting
- ☐ Marinating
- ☐ Meat and poultry patties (with extenders and other ingredients)
- ☐ Pumping
- ☐ Tenderizing (with solutions, massaging)
- ☐ Filtered lard
- ☐ Fresh sausage
- ☐ Margarine

II

- ☐ Assembly of products only
- ☐ Casings
- ☐ Slicing
- ☐ Smoking for appearance and flavor only (no formulation)
- ☐ Acidified products
- ☐ Curing
- ☐ Pizza
- ☐ Dough covered - wrapped product
- ☐ Mechanical deboning
- ☐ Pizza topping
- ☐ Canned (permastik)
- ☐ Corn dogs
- ☐ Cured beef or pork (corned beef)
- ☐ Cured sausage
- ☐ Cured - water added pork products
- ☐ Fried chicken

III

- ☐ Cooked meat - poultry without formulation (open kettle, charcoal, braise)
- ☐ Sandwiches (meat brought from outside plant)
- ☐ Canning (thermally processed / shelf stable)
- ☐ Cooked and - or smoked sausages
- ☐ Dinners - entrees
- ☐ Dry - Semi-dried sausage
- ☐ Imports
- ☐ Meat - poultry pies
- ☐ Certification (freezing, heating, drying)
- ☐ Jerky - Cooked meat / poultry
- ☐ Formulation (frying, barbequing, etc.)
- ☐ Rolls - loaves - luncheon meats
- ☐ ...ified products
- ☐ Cooked and / or smoked pork products
- ☐ Soups - salads - gravy
- ☐ Cooked patties (all)
- ☐ Cooked meats (roast beef, corned beef)
- ☐ Partially deformed (species) fatty tissues

PLEASE ADD ANY PRODUCTS - PROCESSES NOT GIVEN ABOVE

PARTIAL QUALITY CONTROL PROGRAMS/PROCEDURES

LIST BY NAME AND CODE NUMBER ALL APPROVED PARTIAL QUALITY CONTROL PROGRAM(S) AND PROCEDURE(S) *(If more space is needed, use a separate sheet)*	QC PROGRAM CODE NUMBER	DATE APPROVED	
		ORIGINAL	REVISION-AMENDMENT
19			

LIST PLANT'S SPECIAL RULES (i.e., Raw nuts, loose items in shirt coat pockets, smoking, etc.) *(If more space is needed, use reverse)*

20

PAGES 1, 2 AND 3 MUST BE COMPLETED, BEFORE SIGNING.

SIGNATURE OF FSIS INSPECTOR PREPARING FORM	DATE	SIGNATURE OF SUPERVISOR	DATE
21			

ATTACHMENT 1
FSIS DIRECTIVE 8810.1

DATA FOR THE COMMON ON-LINE REFERENCE FOR ESTABLISHMENTS	EST. NO. (Meat) (22)	EST. NO. (Poultry) (22)	EST. NO. (Equine) (22)	EST. NO. (Other) (22)

INSTRUCTIONS: Except where noted, place an "X" in the blocks appropriate for each plant. Make your decisions based on your knowledge of authorized activities for each plant and your observations of activities conducted at each plant.

	MEAT	POULTRY	EQUINE	OTHER
(23) SLAUGHTER DATA	☐ Cattle ☐ Calves ☐ Sheep ☐ Goats ☐ Swine ☐ Reindeer (v) ☐ Buffalo (v)	☐ Young Chick ☐ Mature Chick ☐ Turkeys ☐ Geese ☐ Ducks ☐ Guineas ☐ Rabbit (v)	☐ Equine	
PROCESSING DATA (24) Breaking / Cutting Boning Mechanical Boning Fabricating Curing Formulating Cooking / Smoking Canning Drying Convenience Items Slicing Fats / Oils	☐	☐	☐	☐

* ID SERVICE CODE TABLE:

N = No ID Service
1 = Plant handling unwrapped meat
2 = Plant that can handle wrapped or boned meat products only
3 = Combination of 1 and 5
4 = Combination of 2 and 5
5 = Approved identification services

OTHER DATA (25)	MEAT	POULTRY	EQUINE	OTHER
ID Service (enter code) * Food Inspection Service Certification Service Voluntary Poultry Inspection Voluntary Equine Processing Animal Food Inspection	☐ ☐ ☐ ___	☐ ☐ ☐ ☐ ___	☐ ☐ ☐ ☐ ___	☐ ☐ ☐ ☐ ___
(26) VOLUNTARY PROCESSING	☐ Beef ☐ Veal ☐ Lamb ☐ Goat ☐ Pork ☐ Buffalo	☐ Poultry ☐ Rabbit		

PLANT INFORMATION

(The entries below pertain to the plant as a whole.)

EXEMPTED ACTIVITIES (27)

☐ Custom Slaughter
☐ Custom Processing
☐ Retail
☐ Buddhist
☐ Confucian
☐ Islamic
☐ Kosher
☐ Other (specify): _____

OTHER INDICATORS (28)

☐ IRE
☐ ERAE
☐ Fish Inspection
☐ Inedible Fats
☐ Edible Fats
☐ Ined. Fat Shipper
☐ Rail-siding
☐ HQ Point

FSIS FORM 8810-1 (7/88) PAGE 3 OF 3

FSIS Form 8810-1,
PLANT PROFILE

GENERAL INSTRUCTIONS

1. The plant profile form is a three page form and is to be maintained as a set.

2. The form is to be completed in duplicate by the inspector-in-charge.

3. The original copy of the form is to be filed in the Government office, convenient to all assigned inspectors. Where available, the old plant profile, FSIS Form 7620-6A, is to be attached to the original copy. The copy will be sent to the Area Office through supervisory channels.

4. All blocks must be completed. In some instances, merely placing an "X" in a block will be all that is necessary.

5. If additional information is listed on the back of the form, or attached on a separate sheet, be sure to reference the additional information to the appropriate block and section of the form.

DETAILED INSTRUCTIONS

PLANT PROFILE FORM (Page 1)

NOTE: The numbers in this part of the instruction, relate to the circled numbers on the Form.

1. **Plant Name and Location.**
Enter plant name and location; give a brief location description, e.g., street address and zip code, "located 2 miles south of city on road xyz"; or hi-way "xyz"; etc. X and Y coordinates will be filled in by the Area Office. If the mailing address is different than the location address, write mailing address or "same" in 1a.

2. **Inspection System.**
"X" the appropriate block

3. **Type of Plant.**
"X" the appropriate block

4. **Quarterly Volume.**
Use the most recent quarter's production volume. If quarterly; production figures are not available, divide last years total volume by 4 and enter results.

5. **Region Name/Number.**
Identify the Region by name or abbreviation. e.g., Western or WRO; Southwestern or SWRO; North Central or NCRO; Southeastern or SERO; Northeastern or NERO.

Each region also has a number designation, e.g., WRO = 2; SWRO = 3; NCRO = 4; SERO = 5; NERO = 6.

6. **Area Name/Number.**
Identify the area by name and number, e.g., Austin/10, Albany/04, etc.

7. **Circuit Name/Number.**
Identify the circuit by name and number, e.g., Ft. worth/25, Portland/09, etc.

NOTE: Region, Area, and Circuit numbers may be found in FSIS Directive 1010.3, Revision 1., dated 9/4/86 or in the MPI Directory.

8. **Establishment Number.**
Enter the establishment number. If the plant processes both meat and poultry, write both numbers, e.g.,
Meat Plant----------00038--M
Poultry Plant----------00042--P
Both Meat & Poultry Plant-00038--M/00038--P

9. **Approved Hours of Operation.**
Enter the hours of operation approved by the Area Supervisor. List the beginning and ending for each day. If the plant operates more than one shift, use second shift blocks, and write third shift information on the back of the form. Please use military time for entering clock hour information.

10. **Slaughter/Processing Combination.**
"X" this block if the plant slaughters and processes meat or poultry products.

10a. **Pure Processing.**
"X" this block if plant conducts processing operations only.

10b. **Custom Exempt Operations.**
"X" this block if plant conducts custom exempt operations.

10c. **Retail Exempt Operations.**
"X" this block if plant conducts retail exempt operations.

11. **Production Area.**
Enter the production area in square feet. This information can be found on the approved blueprints. Include only production areas, shipping and receiving areas, lunch rooms, dressing rooms, locker rooms, toilets, warehouses, and other areas where the assigned inspector has inspectional responsibilities. DO NOT include outside premises.

12. **Complexity.**
Enter the highest complexity level (simple, medium, or complex) for each shift. Refer to FSIS Directive 1030.2 Documentation of Processing and Combination Assignments, dated 4/22/85. You may request this information from your supervisor. If there is only one shift, use N/A in second shift block.

13. **Plant Management Names.**
Enter the name(s) of the plant official and their titles. You may write in the titles if different from those listed on the form. Use the back of the form if more space is needed.

If the plant has Quality Control personnel, "X" the appropriate block and write in the name(s).

14. **Federal, State, or Local Requirements.**
Each Region, Area, Circuit, or Assignment can vary as to necessary certificates, letters, permits, etc. You should check to determine if each required form is on file. Enter the dates listed on the current record. Use a pencil to identify the due dates since some forms may be subject to change. Your assignment may require certificates, letters, permits, etc. that are not listed on this form. If so, use the back of the form if you need more space.

15. **List Government Office, Facilities and Services.**
Identify the government office location within the plant, location of rest rooms, lockers (if provided), laundry facilities, etc. List anything else that could make it easier for an inspector entering plant to locate various facilities.

16. **Special Telephone Codes.**
List various codes necessary to operate the telephone, e.g., how to reach outside line; how to contact various departments within the establishment; how to contact the Area Office; how to contact Circuit Supervisor; etc. Include area codes. **DO NOT list credit card numbers.**

17. **FSIS Designated Parking Slot.**
"X" the appropriate block. If "yes" is marked, describe the parking location, slot number, etc.

PLANT PROFILE FORM (Page 2)

18. **Product and Operations Profile.**
Enter an "X" in all appropriate blocks for products or processes that are part of this establishment's operation. Also add any product or process not listed.

19. **Partial Quality Control Programs or Procedures (PQCP).**
List by name each approved PQCP or procedure. Also list the three digit QC program code number. (The number is part of the approved program and can be found near the top of the first page).

20. **List Plant's Special Rules.**
Leave this block blank. Information on special rules is available in the Government office in accordance with General Instructions, Attachment 2, Item 3, FSIS Directive 8810-1.

21. **Signature and Date.**
After completing the form, the inspector preparing the form will sign and date page 2. Forward a copy of the completed form to the Circuit Supervisor for signature.

PLANT PROFILE FORM (Page 3)

22. **Establishment Number.**
Enter the establishment number. If the plant slaughters or processes more than one species, use the appropriate blocks, e.g.,

	Meat Plant	00038--M
	Poultry Plant	00042--P
	Equine Plant	00038--E
(Other)	Animal Food Plant	00038--A
	Inedible Animal Fat Shipper	00038--A

23. **Slaughter Data.**
Enter an "X" in the blocks beside those species slaughtered at this establishment.

24. **Processing Data.**
Enter an "X" in the appropriate blocks, if applicable at this establishment. Note that the processing data is segregated by establishment number for meat, poultry, equine, and other.

NOTE: If working with source documents, the FSIS FORM 5200-2 (formerly MP Form-401) and MP Form 225 will be useful.

25. **Other Data.**
Enter an "X" in the appropriate blocks, if applicable. Also write in ID service code, (from table above).

26. **Voluntary Processing.**
Enter an "X" in the blocks beside those species processed at this establishment.

27. **Exempted Activities.**
Enter an "X" in the appropriate blocks, if applicable.

28. **Other Indicators.**
Enter an "X" in the appropriate blocks, if applicable.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE | 8820.1 | 9/21/88

CORRECTIVE ACTION SYSTEM

I. PURPOSE

This directive prescribes corrective action procedures for processing operations in Federally inspected plants. It also provides guidelines for identification/classification, documentation, notification and correction of deficiencies observed while conducting inspection and monitoring activities under the PBIS. FSIS Form 8820-2 and instructions for completion are also transmitted with this directive.

II. [RESERVED]

III. [RESERVED]

IV. REFERENCES

MPI Regulations, 9 CFR, Chapter 3;
FSIS Directive 5400.1, dated July 1988;
FSIS Directive 9020.1, dated 12/10/81;
FSIS Directive 8410.2, dated 06/03/88.

V. ABBREVIATIONS

The following will appear in abbreviated form in this directive:

CAT	Corrective Action Termination Procedure
ERAIE	Establishments Requiring Additional Inspection Effort
IIC	Inspector in Charge
IRE	Intensified Regulatory Enforcement
MPI	Meat and Poultry Inspection
PBIS	Performance Based Inspection System
PDR	Process Deficiency Record
PEA	Progressive Enforcement Action
PQC	Partial Quality Control
QC	Quality Control
TQC	Total Quality Control

DISTRIBUTION: All MPI Offices, All Processing Plant Managements, Compliance Offices, ICL, Hq and Field

OPI: MPIO

VI. DEFINITIONS

A. **Deficiency Classification Guide.** A system for assessing the relative significance of findings from inspection tasks performed in plants. The guide relates inspector observations to a series of questions about plant process controls and results in a conclusion that the deficiencies are critical, major or minor.

B. **Official Control Actions.** Application of U.S. Retained or U.S. Rejected tags to restrict/control product movement or activities, according to applicable directives and regulations.

C. **Process Deficiency Record.** A descriptive record of the specific inspector findings of a deficiency and establishment corrective actions.

D. **Performance Based Inspection System.** A structured, automated system to schedule inspector work and record findings.

E. **Progressive Enforcement Action.** Reserved.

VII. GENERAL POLICY PROVISIONS

A. Establishments operating under Federal inspection are responsible for producing safe, wholesome, and properly labeled products in accordance with applicable USDA rules and regulations. This involves taking appropriate actions to prevent or correct any conditions that could lead to violations. All establishments are expected to identify and correct such conditions, to take appropriate actions to prevent their recurrence, and to comply with the standards and procedures identified in approved QC programs and systems. In the event deficiencies are identified by FSIS inspection personnel, establishments are expected to propose and institute corrective actions in a timely manner in consultation with FSIS personnel. Sections in this directive requesting establishments to document by a written response to identified deficiencies on Agency forms are voluntary.

B. FSIS is responsible for conducting inspection and monitoring activities that permit an accurate and timely assessment of establishment conditions or instances of noncompliance that could lead to violations. The Agency inspection personnel are to communicate inspection findings and observations to designated establishment management personnel and to verify that proposed corrective actions have been properly taken. FSIS is also responsible for taking official control over

an establishment's product or process, if necessary, to protect public health or economic welfare. FSIS may also recommend additional regulatory action when significant violations or repeated instances of noncompliance occur.

C. CAT identified in Part 18.6 of the MPI Manual and TQC Policy Part E, has proven to be an effective method for identifying to establishment management deficiencies observed with PQC programs and TQC system. Therefore, under PBIS, the CAT procedures will remain in effect except for inspection results that do not conform to the standards identified in the QC program/system. Those results will be documented on the PDR for discussion with plant officials during the exit conference. Such inspection results should not be identified on the inspection schedule as a deficiency unless it meets the decision criteria for a critical, major, or minor deficiency. All PDR's associated with approved PQC programs shall become part of the CAT file. All PDRs issued in TQC establishments will be placed in the CAT file for subsequent followup action.

VIII. PROCEDURES

A. **Identification/Classification.** The FSIS inspector is expected to:

1. Perform tasks as scheduled. Identify to establishment management all deficient tasks which include results from the following:

   (a) scheduled tasks

   (b) unscheduled tasks

   (c) laboratory or in-plant tests

   (d) evaluation incidents

   (e) FSIS Form 8140.1 (formerly MP Form 437) reports

2. Classify deficiencies using the Deficiency Classification Guide, Attachment 1. Product, equipment, facilities, etc., involved in critical deficiencies will require application of a U.S. Retained/Rejected Tag. Minor deficiencies will not require use of a U.S. Retained/Rejected Tag. FSIS inspectors will determine when a U.S. Retained/Rejected Tag should be applied to product, material or equipment involved with deficiencies classified as major. When a tag is applied, an establishment management representative will be notified. The FSIS inspector will record the classification of each deficiency

on the Inspection Assignment Schedule, FSIS Form 8800-2, dated 7/88.

B. **Documentation.** The FSIS Inspector is expected to:

Document deficiencies on the PDR, Attachment 2. The PDR will be completed in triplicate, each day that a deficiency is noted. The PDR will serve as official documentation, notification, and status of deficiencies to establishment management of non-conforming activities and/or deficient conditions observed or encountered during the performance of inspection tasks.

As noted in the instructions for completing the PDR, inspectors will record deficiencies in Block 7 on a daily basis. MP Form 35, U.S. Rejected-U.S. Retained tag, when used, will be referenced on the PDR. Deficiencies identified and corrected immediately or before the inspector leaves the establishment will be noted on the PDR and identified as "corrected."

C. **Notification.** PDRs will be presented to establishment management during the exit conference. During this conference, the inspector is expected to:

1. Inform management that assurance must be proposed to the IIC or designee for corrective action for deficiencies involving official control actions. Request the proposed or completed corrective action be documented on Page 2 of the PDR. The establishment's proposal should address correction of the immediate problem and actions taken to prevent recurrence of the problem.

2. Identify to management those deficiencies not officially retained or rejected and inform them that corrective action will be verified on subsequent visits and that failure to correct deficiencies in a timely manner may result in additional regulatory action.

D. **Correction of Deficiencies**

1. The establishment management is expected to:

a. Institute timely corrective action on deficiencies identified by FSIS inspection personnel.

b. Contact the IIC or designee to seek release of officially controlled items that were not corrected while the inspector was on the premises.

2. The FSIS Inspector is expected to:

a. Review the open PDR file daily.

b. Verify establishment management's corrective action on deficiencies not requiring official control actions during performance of scheduled tasks.

c. Notify the next level of program supervision if deficiencies are not corrected in a timely manner.

d. Evaluate the establishment's proposed corrective action on officially controlled deficiencies and verify identified proposed action.

e. Close out the PDR by completing applicable sections on the PDR form.

f. File PDR in closed PDR file or CAT file.

IX. PROGRAM SUPERVISOR ACTION

A. Program supervisor will assess, on a periodic basis, inspection findings and evaluate each situation involving patterns of repetitive deficiencies or continued failure to correct identified deficiencies. The supervisor will initiate further corrective action as indicated by the significance of incidents or patterns.

B. FSIS Directive 9020.1, Establishments Requiring Additional Inspection Effort, and FSIS Directive 8410.2, Intensified Regulatory Enforcement, identify procedures to be followed in situations involving serious and/or chronic violations of meat and poultry regulatory requirements.

C. Progressive Enforcement Actions. Reserved.

Administrator

Attachments
1 - Deficiency Classification Guide
2 - PDR and Instructions for Completion

Deficiency Classification Guide

The Deficiency Classification Guide is an aid to classification of deficiencies found during visits to plants and covers both scheduled and non-scheduled tasks. If tasks reveal that the plant has properly controlled production and initiated corrective action when problems arise within a process, the inspector will not record deficiencies.

Classification of deficiencies involves what is known for a fact, and what is reasonable to conclude based on immediate observations and information available. It uses a "Decision Tree" to assess relative importance of findings. The "Decision Tree" process will provide a basis for inspectors to explain their conclusions about the seriousness of deficiencies to plant representatives during exit conferences. It will also be used for correlation of deficiency classifications among inspectors and by supervisors in technical review of inspector decisionmaking. The "Decision Tree" should be used along with training materials and other guidelines to structure inspector reporting and corrective actions.

DECISION TREE

		_CERTAIN	LIKELY	POTENTIAL
IS THE PROCESS RESULTING IN ADULTERATED OR MISBRANDED/MISLABELED PRODUCT?	Check (A) One			
IS THE PRODUCT LIKELY TO REACH CONSUMERS?	Check(B) One			
WILL THE PRODUCT HAVE A DETRIMENTAL EFFECT UPON THE CONSUMERS?	Check (C) One			

A CRITICAL DEFICIENCY MUST SHOW "CERTAIN" IN "A", "B", AND "C".

A MAJOR DEFICIENCY MUST SHOW NO LESS THAN "LIKELY" IN "A", "B", AND "C".

A MINOR DEFICIENCY EXISTS WHEN "POTENTIAL" IS SHOWN IN ANY OR ALL OF THE "A", "B", OR "C" CHOICES.

Note: A critical deficiency should not be recorded unless tasks disclose that plant controls are failing to prevent adulterated or misbranded products from reaching consumers. Inspectors should take appropriate action to control the problem and contact their supervisor as soon as possible.

DEFINITIONS

CERTAIN: Inevitable or seems inevitable, with 95% probability.
LIKELY: Reasonable to assume, but not certain; with 25 to 95% probability.
POTENTIAL: Low probability; with less than 25% probability.
DETRIMENTAL: Injurious to health or significant departure from consumer expectations.

ATTACHMENT 2
FSIS DIRECTIVE 8820.1

The request to this information is Voluntary. It is needed to monitor defects found during [illegible]. It is used by FSIS to determine whether establishments are in compliance. 9CFR 301.320 and 9CFR 381. FORM APPROVED OMB NO. 0583-0015

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE MEAT AND POULTRY INSPECTION OPERATIONS **PROCESS DEFICIENCY RECORD**	1. DATE	2. RECORD 3. EST. NO.
4. TO (Name and title)	5. INSPECTOR	

6. PERSONNEL NOTIFIED

7. DESCRIPTION OF DEFICIENCY AND LOCATION (Including MP 8.1 and 1 subsection [illegible])

A

B

C

8. SIGNATURE OF INSPECTOR	9. DATE

FSIS FORM 8820-2 (7/88) REPLACES FSIS FORM 7610.2 (10/85) WHICH IS OBSOLETE

FSIS FORM 8820-2 (REVERSE)

10 PLANT MANAGEMENT OFFICIAL'S REPLY

A

B

C

11 SIGNATURE OF PLANT OFFICIAL | 12 DATE

13 FOLLOW-UP FSIS INSPECTOR'S ACCEPTANCE SIGNATURE

A. SIGNATURE | DATE

B. SIGNATURE | DATE

C. SIGNATURE | DATE

INSTRUCTIONS FOR COMPLETING FSIS FORM 8820-2
PROCESS DEFICIENCY RECORD

Front of Form:

Block 1. Enter month, day, year (June 16, 1988)

Block 2. Use numerical sequence, entering count, year (i.e. 1-88, 2-88

Block 3. Enter establishment number (i.e. 00038--M; 00042--P; etc.)

Block 4. Enter name and title of establishment representative (i.e. Mr. L. B. Wright, Plant Manger)

Block 5. Enter name and title (i.e. John Doe, FSIS Inspector)

Block 6. Enter name (i.e. J.R. Jones and L. B. Wright)

Block 7. Record all discrepancies on the PDR. Up to three deficiencies may be recorded on a single PDR - record each deficiency in the space 7A, 7B, 7C, as provided.

Record the task code number (located on the schedule, and/or the Inspection System Guide) that refers to the task that resulted in the discrepancy.

Record the deficiency classification: e.g. Minor - Major - Critical

Describe each discrepancy in clear, concise detail. There must be no question about what it is that you found that needs correction.

Identify the exact location of the problem; be it a crack in the wall, or a gondola of retained product.

Block 8 & 9. Self-explanatory.

INSTRUCTIONS FOR COMPLETING THE REVERSE SIDE OF FSIS FORM 8820-2

A. Plant Management Responsibilities.

Block 10: The written response must address correction of the immediate problem and identify action to prevent recurrence.

Block 11 & 12: Must be signed and dated by responsible plant official.

B. FSIS Responsibilities.

PDR's containing a single entry:

Block 13: FSIS representative's acceptance signature and date, if plant management's reply and action are acceptable.

Block 13: FSIS representative's follow-up action/date (Enter action taken and date. If no follow-up is required, close out PDR).

PDRs with multiple entries and staggered completion dates:

Block 13: FSIS representative's acceptance signature and date, if plant management's replies and actions are acceptable, after each discrepancy has been verified.

Block 13: List separately each discrepancy verified by date and signature of inspector verifying corrective action. Include: FSIS representative's follow-up action/date, when appropriate. (Enter action taken and date. If no follow-up-is required, and when all discrepancies have been verified as acceptable, close out PDR and file.)

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

10,140.1 Rev. 1	1-11-88

USE OF DISPOSABLE SHIPPING CONTAINERS

I. PURPOSE

This directive prescribes the use and procedures for obtaining supplies for disposable shipping containers. The one-way disposable shipping container is intended primarily for use by FSIS inspectors to mail food chemistry samples which do not require insulation or other special handling.

II. CANCELLATION

This directive cancels FSIS Directive 10,140.1, dated 11/5/85, and FSIS Directive 10,140.1, Amendment 1, dated 3/6/86.

III. REASON FOR REISSUANCE

To delete MP Form 128-5, California State Laboratory, from the list of mailing labels in paragraph V of this directive. The California State Laboratory is no longer under contract with FSIS to perform sampling.

IV. REFERENCES

Section 23.5, MPI Manual; FSIS Directive 10620.1, Amendment 3, dated 4/8/86.

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated or otherwise referred to in this directive.

ASD	Administrative Services Division
DSC	Disposable Shipping Container
PSB	Program Services Branch, ASD
MPIO	Meat and Poultry Inspection Operations
RO	Regional Office

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID

OPI: SCI/FSLD

MP Forms 128 through 128-6, color-coded, preaddressed, pressure sensitive mailing labels:

MP Form 128	Eastern Laboratory	(green)
MP Form 128-1	Webb Foodlab, Inc	(blue)
MP Form 128-2	Midwestern Laboratory	(red)
MP Form 128-3	Kentucky State Laboratory	(purple)
MP Form 128-4	Western Laboratory	(warm red)
* * *		
MP Form 128-6	(Not preaddressed) 1/	(black)

1/This form is reserved for DSC use to mail samples to locations other than listed above.

VI. POLICY

A. DSCs will be used to ship food chemistry samples (i.e., added water, added substance or total fat analysis) to the Field Service Laboratories and Contract Laboratories to the fullest extent possible. DO NOT USE DSCs if:

1. Use of the DSC is not practical, or

2. Instructions for mailing a particular sample or type of sample state otherwise.

B. The following are considered DSC materials:

1. Box, shipping, corrugated (6 3/4" X 6 3/4" X $7\frac{1}{2}$", 275 lbs. bursting strength).

2. Tape, polypropelyene (2" width).

3. Bag, plastic sample (see Section 23.5 or the MPI Manual for specifications).

4. Rubber bands.

5. Label, mailing, preaddressed, pressure sensitive, color-coded, preprinted with PRIORITY MAIL, PERISHABLE.

VII. RESPONSIBILITIES

A. MPIO

The MPIO, RO, shall provide a projected estimate for the number of food chemistry samples, by region, to PSB. This will enable PSB and the regions to determine each region's DSC material requirements.

B. Program Services Branch, ASD

1. Initial Supply

a. Determine the amount of DSC materials to be ordered using the information provided in FSIS Directive 10620.1, Amendment 3, on "Destination Laboratories for Surveillance and Special Samples".

b. Order and receive the INITIAL consolidated consignment of DCS materials.

c. Distribute the INITIAL supply of DSC materials to the headquarter establishments or non-patrol establishments.

2. Resupply

a. Determine the amount of DSC materials to be ordered, based on requests from the regions.

b. Place consolidated orders for bulk shipment to REPLENISH regional DSC inventories.

c. Inform the regions of expected delivery dates.

d. Determine and maintain an adequate backup supply of DSC materials for the regions, the Agency's other users, and special projects.

C. Regional Offices

1. Determine adequate supply levels based on stock levels and MPIO estimates for food chemistry samples.

2. Contact PSB for DSC supplies.

3. Distribute DSC materials to REPLENISH stock levels at headquarter establishments or non-patrol establishments (the initial distribution will be handled by PSB).

4. Maintain an adequate backup supply of DSC materials for the FSIS inspectors. It is recommended to establish the DSC stock at a 1-month level.

D. FSIS Inspectors

1. Disposable Shipping Container

a. Use DSC to the fullest extent possible to ship food chemistry samples (i.e., added water, added substances or total fat analysis) to the Field Service Laboratories or Contract Laboratories.

b. Maintain an adequate stock of DSC materials.

(1) Subsequent to receiving initial stock of DSC materials, it is recommended that inspectors maintain the stock at a 6 to 12-month level. When reordering, it may be necessary to increase or decrease the number from the initial supply as appropriate to maintain an adequate supply. Do not allow stock to fall below a 2-month supply level before reordering.

(2) To replenish DSC materials, contact RO through normal channels. Allow 3 weeks for DSC material deliveries.

2. Film-Box Container. Upon receipt of DSC materials, use film boxes on hand only for shipment of food chemistry samples to the Field Service Laboratories or Contract Laboratories until film-box stock is depleted.

E. Field Service Laboratories and Contract Laboratories

1. Disposable Shipping Container

a. Handle sample received by DSC as prescribed in Section 23.5 of the MPI Manual.

b. Dispose of the used DSC as prescribed by Science policy and/or PSB.

2. Film Box Containers. Handle sample received by film-box container as prescribed in Section 23.5 of the MPI Manual.

Administrator

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D C

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☒ AMENDMENTS
☐ OTHER

FSIS Directive-Destination Laboratories for Surveillance Residue Testing	10,620.1 Amend. 4	7-7-88

I. **PURPOSE**

This document transmits an amendment to FSIS Directive 10,620.1.

II. **CHANGES**

This Amendment identifies by region, two laboratories to which sulfonamide samples would be sent by the Domestic Program, and changes Clorsulon sampling from the Eastern Laboratory to the Western Laboratory. The sections which are to be changed are B.1 on Page 1, D. on Page 2, and F. on Page 3.

III. **FILING INSTRUCTIONS**

File this Amendment with FSIS Directive 10,620.1.

III. **CANCELLATIONS**

Amendment 3 to FSIS Directive 10,620.1, dated 4/8/86, is cancelled.

Lister M Crawford

Administrator

Attachment

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science Offices, Compliance Offices, TRA, ABB, R&E, AID, IFO

OPI: SCI/FSLD

DESTINATION LABORATORIES FOR SURVEILLANCE AND SPECIAL SAMPLES

A. Send antibiotics and Chloramphenicol samples including confirmation of positive samples for STOP to:

Organization	Laboratory
1. Domestic Program (Region)	
Northeastern, Southeastern	Athens, Georgia
North Central, Southwestern	St. Louis, Missouri
Western	Alameda, California
2. Import Program	
IFO'S 1, 2, 3, 4, 5, and 6 (F Samples)	Athens, Georgia
IFO'S 7 and 10 (F Samples)	St. Louis, Missouri
IFO'S 8 and 9 (F Samples)	Alameda, California

The Laboratory for Import Program "S" samples will be designated on a case-by-case basis with the concurrence of the Director of the Field Service Laboratories Division.

B. Send Sulfonamide samples to:

Organization	Laboratory
1. Domestic Program (Region)	
+[Northeastern, Southeastern, Southwestern	St. Louis, Missouri
North Central, Western	Alameda, California]+
2. Import Program	
IFO'S 1, 2, 3, 4, 5, and 6	Athens, Georgia
IFO'S 7, 8, 9, and 10	St. Louis, Missouri

C. Send Chlorinated Hydrocarbon, PBB, PCB Samples to:

Organization	Laboratory
1. Domestic Program (Region)	
Northeastern, Southeastern	Athens, Georgia
Western, North Central and Southwestern	Alameda, California
2. Import Program	
IFO's 1, 2, 3, 4, 5, and 6	Athens, Georgia
IFO's 7, 8, 9, and 10	Alameda, California

D. Send Albendazole, Arsenic, ***, Decoquinate, Ivermectin, Kepone, Lasalocid, Mercury, Monensin, Morantel and Pyrantel Tartrate, Narasin, Nitrosamines, Selenium, and trace elements (heavy metals), samples to:

Organization	Laboratory
1. Domestic Program (Region)	
All Regions	Athens, Georgia
2. Import Program	
All IFO's	Athens, Georgia

E. Send Amino Acids, Amoxicillin, Benzimidazoles, Carbadox, Dibutyltin Dilaurate, Diethylstilbestrol (Chemistry), Ethylene Dibromide, Gentamycin, Ipronidazole, Levamisole, Melengestrol Acetate (MGA), Narasin, Phencyclidine (PCP), Styrene, Thiabendazole, Tylosin and Zeranol samples to:

Organization	Laboratory
1. Domestic Program (Region)	
All Regions	St. Louis, Missouri
2. Import Program	
All IFO's	St. Louis, Missouri

F. Send Apramycin, +[Clorsulon]+, Halofuginone, Larvadex (R) (Cyromazine) and Pentachlorophenol (PCP) to:

Organization	Laboratory
1. Domestic Program (Region)	
All Regions	Alameda, California
2. Import Program	
All IFO's	Alameda, California

G. Send Estrogenic Compound (Histopathology) samples to:

Organization	Laboratory
1. Domestic Program (Region)	
Northeastern, Southeastern	Athens, Georgia
North Central	St. Louis, Missouri
Southwestern, Western	Alameda, California
Import Program	
IFO's 1, 2, 3, 4, 5, and 6	Athens, Georgia
IFO's 7 and 10	St. Louis, Missouri
IFO's 8 and 9	Alameda, California

*U.S. GOVERNMENT PRINTING OFFICE:1989-242-068: 00017/FSIS